

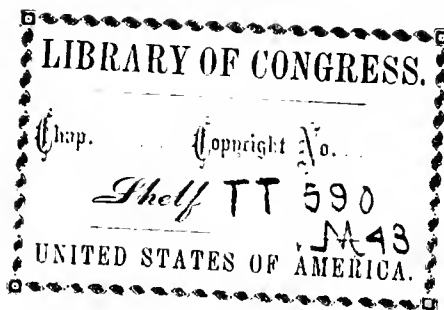
H. MATHIESON'S  
PRACTICAL SYSTEM  
FOR  
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# H. MATHESON'S SCIENTIFIC AND PRACTICAL GUIDE

FOR THE  
TAILOR'S CUTTING DEPARTMENT,  
BEING A COMPLETE TREATISE ON  
MEASURING, DRAFTING, AND MAKING-UP,  
IN ALL STYLES  
FROM CHILDHOOD TO OLD AGE.

ILLUSTRATED WITH NUMEROUS DIAGRAMMS AND ENGRAVINGS.

THIS GREAT AND UNRIVALED SYSTEM WILL PRODUCE A BEAUTIFUL DRAFT  
IN FIVE MINUTES, IF IN THE HANDS OF ANY EXPERT CUTTER.

NEW YORK:  
H. MATHESON.  
1871.

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## PREFACE.

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In the following work I have attempted, and I trust with great success, to supply my fellow-craftsmen with what long ago I considered as a desideratum, namely, a Treatise on Measuring, Drafting, &c. While it should give Instructions on the Art and Science of Cutting, it should also discuss Tailoring thoroughly in a liberal spirit and sound principles. How far I have succeeded is for the Trade or the profession to determine.

In the course of the demonstration various suggestions as to the mode of making up, and the means which may be adopted to please the customer's taste as well as the fit of his person, have been interspersed. These will be found to be, at least, not irrelevant to the objects of the work ; and I hope that amidst these light and extemporary digressions something more than mere amusement will be found. My aim has been to point to a train of thinking which I have found both useful and agreeable in the pursuit of my business, and to induce Tailors and Cutters to acquire for themselves some knowledge of the science of Anatomy and the art of Drawing, as both will be serviceable for the Cutter at all events, if not for the Tailor, and will furnish an immense stock of profitable thought and pleasing recreation for leisure time.

Following the System of Measurement and Drafting general observations are given with respect to peculiarly formed persons, which, from the very nature of the subject, requires to be treated scientifically and in a practical manner, laid down by scientific rules for all forms of persons, and every character of garment in use by fashionable gentlemen. I would inculcate the urgent necessity of attending to the figure, gait, and bearing of customers, as it will be of incalculable value to the Cutter to attend to those observations. There is one circumstance which requires particularly to be noted, which is only the one mode of demonstration used in all parts of the work, as in Boys' and full grown Men's clothing.

I have adopted a plain but a correct narrative form of demonstration, using only the names of the various parts of the garment. This form I have chosen for the purpose of making my system intelligible and easily learned by those who might not be acquainted with the method of demonstration employed in mathematical and mechanical work. The system is got up on the most scientific method of demonstration by reference letters, adopted in another part of this work.

With respect to the cuts and diagrams of this work they speak for themselves. This is, I believe, the first attempt of any inventor or publisher of a System of the Art of Cutting to teach and give instructions in cutting and making up, showing how every part of a garment ought to be put together in a practical and workman-like manner. Then in the words of the great Philosopher, "Let thy light go forth in order that it may shine its radiant shadows, and disclose and impart knowledge to those that are but partially out of darkness."



## INTRODUCTION.

---

It is now over thirty years since I cut and made the first coat, and twenty-two years since I entered the Tailoring business on my own account. The skill of tradesmen was not so severely tested then as it is now. However that excellence of workmanship has become indispensable to success, it is more imperative than ever that he who would impart instruction in any art or science should be possessed of a thorough and practical knowledge of what he teaches.

From my long experience and favourable circumstances in business, I trust that I shall be found to possess the qualifications so much requisite to communicate a clear and practical knowledge to others. This system of cutting is not an invention of the departed, or any one living except myself, and is not got up for a speculation, but from a desire to do good to my fellow-man. It has been tested for the last eight years extensively under my own immediate observation and in my own hands, with the greatest success ever known in fitting customers, without trying on or refitting, as is usually done. The system is simple and easily learned ; a practical Cutter can learn it in less time than he can cut a coat, and put it in operation with the greatest ease after he drafts the first coat.

For accuracy, elegance of design, and rapidity in executing a draft, it has no rival in the profession, as it will draft a coat in five minutes and use less cloth, or, at all events, as small a quantity as any pattern in existence. Patterns are a thing of the past with this system, and will only be used hereafter by inferior cutters and old fogies.

For example : two persons may be exactly the same measurement round the breast, &c., yet it often occurs that a coat made for the one will not fit the other. This renders the examining of the figure of the individual to be fitted frequently of greater use than a carelessly taken measure. In order, therefore, the more readily to draw to the subject the observation of those who may partially or altogether neglect so essential a point, this work is illustrated with a series of engravings and diagrams, exhibiting the human figure as most ordinarily seen in our every day walk, together with examples of those irregularities and deformities of shape which nature occasionally presents to our view. Correct measurement being of the greatest consequence, the altitude of the individual as he walks, rather than as he stands, should be the study of the Cutter. Almost every person stands extra erect while his measure is taken, so that an individual on such an occasion may appear straight who has in reality a considerable stoop. To provide for this I have introduced a system of measuring suitable for the stooping as well as for the erect position, which will never fail if attended to. I have tested the system for a long time before I ever thought of introducing it to the public, and found it perfect in all its

workings, from the lowest to the highest number on the gauge ; and I am confident whosoever will test it will never find it otherwise in any part of its operations.

In fact I have tried and tested almost everything in the shape of improvements or inventions in the art of Cutting since my advent into the Tailoring business, but with very little satisfaction. Besides the application of many of these inventions were inconvenient and troublesome to the customer as well as to myself. I will try to describe a few of those systems, as briefly as possible, as I have no doubt but the reader is quite as conversant with them as I am. The first, if I recollect, was a leather strap measure tied round the body under both scyes, and a tape attached in front of scye to go round to all parts of the body. I soon discovered that I was but one of the many victims of the leather strap. My next exploit on the human figure was with a set of brass harness, called a "Transfer." This I had soon to transfer to the back yard, although I gave fifty dollars for the same a few weeks before. I have also invested in the paste-board square and its attachment of scale measures, but with what success it is only necessary for me to say that it was one of the great humbugs of the day. I have cut by the graduated scales of most inventors and publishers of the period, and I find serious objections in them, as being complicated and not founded on the true principles or system of measurement to fit the human body in all its shapes. I can assure the public with confidence that my system is original, and entirely different from anything published heretofore by any other inventor. It is simple and easily put into practice, and brings all the points out necessary to cut any kind of a garment, and in a shape to fit the figure for whom it is cut. The system consists of a twenty-six inch gauge containing all the necessary points to cut coats, vests, and pantaloons in any style, from twenty-two to fifty inches breast. The one side of the gauge contains all the points to draft coats with, the other side all the points to draft vests and pantaloons with. This gauge will draft a beautifully designed and good balanced coat in five minutes, if in the hands of a practical cutter. Vests and pantaloons can be drafted by this gauge in half the time it takes to draft a coat, and equally well designed, in any style now or hereafter. In fact this is the only system on the art and science of Cutting and Tailoring in general that has been published on a new principle, and one that any man can understand and put in practice if he is gifted with the ordinary intelligence of man. All the other systems that I have any knowledge of are only repetitions of the old antediluvian thirds and fourths in one shape or another. To try to describe in this work the importance of this unrivalled science on the art of Cutting would simply be ridiculous, as it can be tested in the hands of any expert cutter in less time than it takes to write it down.

The particulars and utility of this valuable system will be more fully described with the accompanying diagrams, &c.

## PRELIMINARY.

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In the course of my extensive experience with Cutters I have met many that did not even possess the first rudiments of education. This has been, and continues to be, a barrier in the way of instruction, and renders it necessary for me to have recourse to such a method in this work as will make the system simple and intelligible to persons of the most ordinary and limited education, and I trust it will not be any objection to the more refined and cultivated intellect.

All systems of cutting are designated either by letters of the alphabet or by figures. Both of these modes I have found not to be easily understood by many Cutters who begin to study a new system. To obviate this difficulty, I intend through the whole of this work to use only the names of the various points on the gauge, which are only eight in number for the Frock Coat System, and are as follows :—

- S. means Shoulder balance at the top of line No. 4.
- S. P. „ back Shoulder Point on line No. 4.
- B. S. „ Bottom of Scye on line No. 7.
- W. S. „ Width of Scye on line No. 6.
- F. S. S. „ Side body Seam line, No. 8.
- B. „ width of Back lines, Nos. 2, 3, and 4, for back scye.
- T. B. „ width of the Top of Back line No. 5.
- S. H. „ Sleeves Head fore points, line No. 5.

All the above points will be explained hereafter, with the other lines on Diagrams Nos. 2 and 4.

For a Sack Coat dispense with line No. 8, F. S. S. for side body seam. Refer to Diagram No. 2 for Sack Coat.



## MEASUREMENTS.

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I will now proceed with the art of measurement. For a Frock Coat, measure without a coat in the following manner :—Take the gauge and put it on the top of the right shoulder out as far as you can, on its edge and as near horizontal as possible ; then mark a point, with chalk, one inch from the gauge, or according to taste, for the outside shoulder point ; from this point lay the gauge across the shoulder to the back of the neck, hold it firm and mark a point one inch, or according to taste, in front of the gauge for the inside shoulder point ; now lay the gauge on the back, as near horizontal as possible, from shoulder point to shoulder point, and mark at centre or back seam for the rise of back shoulder ; then place the gauge under the right arm and close up to the bottom of seye, mark a point one inch in front of seye, mark another point behind the seye on the side body seam ; from this point lay the gauge across the back, and as near horizontal as possible, mark a point on the centre or back seam.—This is all the gauging for the test measures. Now I will proceed to measure for a Frock Coat : The point one inch in front of seye I make a pivot for test measures, then take the tape measure, with the end firm on the pivot, and measure up to the front shoulder point No. 1, and mark ; then to the back seam at socket bone at No. 2 and mark ; next measure up the centre of shoulder and over transverse the back to No. 3 on the back seam and mark at No. 3 ; next measure over the outside shoulder point and for shoulder point No. 4 ; then to back seye point No. 5 and mark ; then from the socket to the pivot and mark.—This is all the test measures. Now I will commence with the back : Take the end of the tape measure and place at point No. 2, at the socket bone, measure down to shoulder point line and mark ; then to point No. 3 and mark ; then to the natural waist and mark ; then for the length of back and mark ; then for the whole length of back and mark. Next the sleeve measure : First the width of back to point No. 4 and mark ; then to the elbow and mark ; then to the wrist or whole length of sleeve and mark ; then measure round the head of arm or shoulder for sleeve heads and mark. Next measure the width or size of chest and mark ; then the size of waist and mark ; then the width of breast from seye to seye and mark one-half the size.—This concludes the measures for the coat.

REMARKS ON COAT MEASURING.—It is of the greatest importance to a Cutter to acquire a knowledge of the manner and habits of his customer while walking or standing, as it will give him the means of knowing whether he is standing in his natural position or not, as there is nothing more essential to know, while his measure is taken for a coat. I would recommend Cutters to have their customers stand in their natural position, or as near it as possible, and to be careful that the customer does not expand or contract his chest or waist while his measure is being taken

at those points. If the Cutter will give the above remarks his consideration, and be careful in measuring—not to measure too tight or too slack—the result will be that he has a good fit in every garment that he cuts. The Cutter must recollect that all Under Coats, whether Frock Coats or Sack Coats, are measured for by this system without a coat, and Over Coats over the Under Coats.

### VEST MEASURES.

First measure the rise of back shoulder, if you have not a coat measure ; if you have, that rise will do by reducing it half an inch. Take the tape measure and place the end on the back seam at the socket bone, and measure over the shoulder to the desired length for collar and mark ; then down the front of breast for the whole length and mark ; next round the chest and mark ; then round the waist and mark ; then two inches below the waist and mark.—This is all the necessary measures to cut any kind of vest with.

### PANTALOOON MEASURES.

First take the gauge and place it in the crutch or as high up the fork as it can go, in a horizontal position, bend the gauge as much as possible to the right leg and mark with chalk a point. Now take the tape measure and place the end at the desired height of rise for the body, measure down to the point made with gauge and mark ; then to the knee and mark ; then to the sole of boot and mark ; then round the foot for the width of bottom and mark ; then round the knee and mark ; then round the head of thigh and mark ; then round the hips and mark ; then round the waist and mark.—This is all the measures for a pair of pants. The size of legs, &c., must be guided by the Fashion.

REMARKS, ETC.—There are a great many Cutters in the profession that are of opinion that Pantaloonns are quite simple and easy to cut. I would say it is easy enough to cut Pantaloonns but not so easy to fit. To please the customer and his friends, as is often the case, the Cutter must bear in mind that there are as great a variety of styles and shapes to be fitted in pantaloonns as there are in coats ; and that pantaloonns are equally as much exposed to the gaze of other people as coats are. Therefore it is quite necessary that the Cutter should be as competent in cutting pants as he ought to be in cutting coats, for the one are as much used as the other. I would impress upon the mind of the Cutter that he cannot be too careful in paying attention to the manner his customer stands while he is taking his measure. He ought to stand in his natural position, the heels of his boots about three inches apart. In taking the waist measure, a great number of customers are in the habit of expanding or contracting the waist while their measure is taken. The Cutter ought to explain to the customer the result of such procedure, if not discontinued. It must be disadvantageous to both parties if a correct measure is not attained, as a misfit undoubtedly must be the result in all such cases.



## GENERAL REMARKS.

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I trust that it will not be out of place to make a few observations and remarks as regards the different styles of garments in general use by the inhabitants of all parts of the civilized globe. All of those garments that I am about to particularize, have been in use in one shape or another, from time immemorial, and will continue to be to the end of time.

I shall begin my remarks with the Dress and Frock Coats which are essentially the same in all parts of the garment except the skirt, which is explained in another part of this work. The Dress Frock or Double Breasted Coat is the most elaborate piece of workmanship in the whole profession, and is highly prized by every skillful and scientific Cutter and Tailor throughout the universe. Therefore, I would inculcate upon every Cutter, whatever his abilities may be, to use it to the best advantage in designing and cutting. This garment that I am describing, as it ought to fit in every sense of the word, and fit close to the body, but not so close as to form wrinkles in any part of the garment, at the same time shows the figure of the person to good advantage. If you should happen to meet with such a customer that it would be an impossibility to make him a garment of this kind to your advantage or his, I would recommend every Cutter to prevail upon such a person to have some other garment more suitable to his figure; as it would be more advantageous to both parties, or else make up your mind that you have to *make the man*, as the saying is; therefore, you have to build a coat that will make him appear as a man ought to in such a garment, if not, take care that your reputation as a Cutter would not be lowered in the estimation of the public in sending forth an ill-shaped garment.

The next thing is, how are you going to fit a person that is ill formed? You must cut a coat according to the system with the usual measurements, except part of the test measures; dispense with Nos. 4 and 5, over the shoulder point—those two points are of no consequence for the low or drooping shoulders—you must build shoulders of the kind as shown on diagram No. 40; and if one only is low, build the low to match the high one, and this is the only method by which you can put an ill formed person into good shape, and at the same time retain your reputation as a Cutter, which is most essential for your prosperity.

The next garment is a Half-Dress or a Single-Breasted Frock Coat. This garment is in its general principles the same as the Double Breasted Frock, only it has no lapels sewed on the breast and is Single-Breasted instead of Double. It is a

much cheaper garment, even if made from the same cloth; therefore, it is naturally more of a general garment than the Double-Breasted, and is worn by every class of people without distinction, and made of all grades of material; but, like the Double Breasted Frock, it is not suitable for any ill formed persons unless the same means are used in its construction as noted in the foregoing garment.

The next garment is what is generally termed a Walking Coat. This garment is quite a nobby coat, is more worn by the better class of people than the Single Breasted Frock, and is usually made from fine material; and, when well cut and made, it looks neat and stylish, particularly on a well formed person, in fact it has been and is the most popular garment in use; but, like all other close fitting garments, it is not suitable for a person ill shaped. Every Cutter ought to bear in mind to dissuade every person of ill form from getting a close fitting garment.

The next garment is the Business or Shooting Coat. This garment is made in so many shapes, from time to time, and designated under such a variety of names, that it is almost impossible for a great many in the trade to understand and explain to their patrons the style of this garment.

I have known tailors to make a customer one season a business coat, and next season, the same customer selects an English Walking Coat, but when made, to his great surprise, it is found to be identically the same as the business coat, except a trifle more rounding in the skirt, or a little longer or shorter in the waist, as the case may be. At all events, the business coat, as I term it, is a very popular garment with business men, from which it derived its original name.

The next garment is a Sack Coat. This style of garment is more worn by the working class and mechanics, than any other garment, although it is worn by a number of the better class of people; therefore, it has become a very popular garment, as a general thing, and will continue to be so for an indefinite length of time. This garment is made of all kinds of material, and changes its shape from season to season, like every other garment in use. This garment ought to be cut with a broader shoulder than any other coat in the trade, therefore it is very indispensable that the shoulders should be padded, as shown on diagram No. 40. This make will give the coat a good square shoulder, which ought to be on all coats of this make.

The next is an explanation on the manner of making Over-Coats of every description. They should be cut and made in the same manner as under coats, only the skirt ought to be square in every case. The under coats are measured for without a coat, which gives the exact size of the figure to be fitted, while the over-coat is measured for with the under-coat on. This will give the exact size of the person to be fitted, as in the under coat, the only difference is that the one is measured for without a coat, while the other is measured with a coat on. This method of measurement must be quite perceptible, and easily understood by a person of the slightest intelligence whatever; therefore, whether you are measuring for a Double-Breasted Frock Over-Coat or a Sack Over-Coat, the system is so uniform in its

working, that it will draft from the smallest to the largest size, with the same proportions all through. Size is no obstacle to this system.

Vests are made in great variety of shapes and styles. The changes in Vests are quite as frequent as in any other garment made. There are at all times three, four, or more styles in fashion, such as Single Breasted Vest, Single Breasted Roll, Double Breasted Roll, and the Double Breasted Lapel Vest. These styles are never out of fashion, in one shape or another, the only difference is in their construction, sometimes they button very high, and sometimes very low, and sometimes between the two extremes. This is the mode by which the different styles become fashionable.

There is also a great variety of styles in Pantaloon, which change from one shape to another every season. However, there are only four or five styles that have been in use for a long period : such as Plain Pants, Medium, Peg-top, Half Peg-top, Tight-fitting, Half Tight-fitting, Spring and Half Spring Bottom Pants, all of which styles keep coming in and going out year by year ; but in reality there are no other styles than those enumerated here. Any others may be designated from time to time under assumed names different from those here given, but the theory and principle is the same notwithstanding the change of name. Plain pants are worn chiefly by the working classes and military ; Tight-fitting, by the genteel and young fashionable gents ; Peg-top, when in fashion, are worn by every class of people ; and the Spring Bottom pants, which are principally the tight-fitting with a good deal of spring over the boot, are, when in fashion, very generally worn by every class of people. No doubt the latter style will some day be as popular as before. By referring to the Diagrams in this work, and keeping well posted in the Fashions from season to season, the Cutter will not find any obstacles in his way in the art of cutting, by which he would be debarred from cutting a fashionable garment of any kind and at all times. But it is almost indispensable that every Cutter should have the semi-annual reports of Fashions, if not the monthly. By this means he will always be well posted in anything that is brought before the public in design of materials, and may gather many valuable hints in regard to the making up. Such information must be of incalculable value to the Cutter of any fashionable tailoring establishment—if not to establishments of lesser note, it ought to be to the trade in general.

## PRELIMINARY INSTRUCTION IN TAILORING.

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The art of making clothing is as indispensable to the Cutter as the art of cutting, as both ought to go hand in hand. If a garment is ever so well cut, it is an easy thing to spoil it in the making up, which is very often done by inferior and careless Tailors, but I hold that there are a great number of Cutters that are very deficient themselves in the art of making up clothing. Therefore, how can any Cutter be competent to give instructions to his workmen when he has not the necessary attainments so requisite in himself? There are a great many Cutters and Tailors that differ very much about the manner of making a coat, &c., and will do so to the end of time; however, I would say to all Cutters and Tailors, that so long as they will adhere to the following instructions, they will never fail in making a good substantial and neat job:—

The first thing that a Tailor ought to do, when he receives a job from the Cutter or Master Tailor, is to open the job and examine it and see that he has got all the trimmings, and, if not, report immediately. Whatever deficiency there may be, this will avoid any misunderstanding between the Cutter and the Tailor, a thing that ought never to occur,—they should mutually assist each other in their respective avocations.

On finding the trimmings all correct, begin to fit up the job. First cut the size of the pockets and stay all around them; put in the pockets neatly and firmly, whether with flaps or welts, bound or unbound, and press the pockets; then fit the canvas in the breast and shrink it, stretching the fore seye of the cloth and canvas as shown on diagram No. 42; then baste in the canvas and stay the edges, and tack the pockets to the canvas; now pad the lapels neatly towards you, and fit up the facings and linings of the fore part, back and sleeves; then sew the facings and the linings of the fore part together; then pad the facings in a neat manner, stretching the fore seye to match the outside; then baste in the facings and linings and make up the edges, whether bound or unbound; then sew the back and fore parts together, and press well, baste in the back lining and fell over the side body seams; then sew the shoulder seams and press; overcast the canvas and facings on the shoulder seams and fell over the lining of the back shoulder; then sew the sleeves and sleeve linings and press, overcast with a fine silk thread the side body and back scyes, and the gore of the collar; then measure the sleeve heads with scyes and if any too large draw the head in with a fine silk thread, and press back the fulness; “the sleeve heads should never be cut too small;” then put in the sleeves and press the heads,

fell the sleeve lining over the seyes ; then smooth down the linings in the sleeves and fell round the cuffs or bottom of the sleeves—when there is no cuff facings to the sleeves they ought to be interlined or stayed from 3 to 4 inches with fine linen or good salicia, under the sleeve lining this will keep the cuffs a little firmer than the rest of the sleeves and will give them a much better appearance ;—then fit the under collar with canvas, and draw in for the stand at  $\frac{3}{4}$  of an inch less than one-half the width, and shrink it into a half circle, shrink the covering to match the under part ; then fit the collar to the gorge, and if too long, which is often the case, cut off at both ends to the desired length, and begin to sew at the centre of back both ways to the ends ; then seam the upper collar to the lapels or facings of the gorge ; then turn it over and baste smooth, and fell all around ; then make the button holes and press of the coat in a careful manner, in order to retain its former shape, and put on the buttons and the coat is finished.

This description will apply to the making of a Sack Coat as well as a Business Coat, only when a Sack Coat is without a vent behind, the edges cannot be made up until the back and fore part are put together, especially when bound. In conclusion, I would impress upon the memory of every Tailor, that he cannot be over careful in pressing off a coat, as it is very important that the coat should retain the shape that it was put in, when padded, &c. I have known a great number of Tailors that destroyed the appearance of a coat in pressing off ; there is no use in trying to shape a coat into good form when building it, if it is pressed out in the finishing.

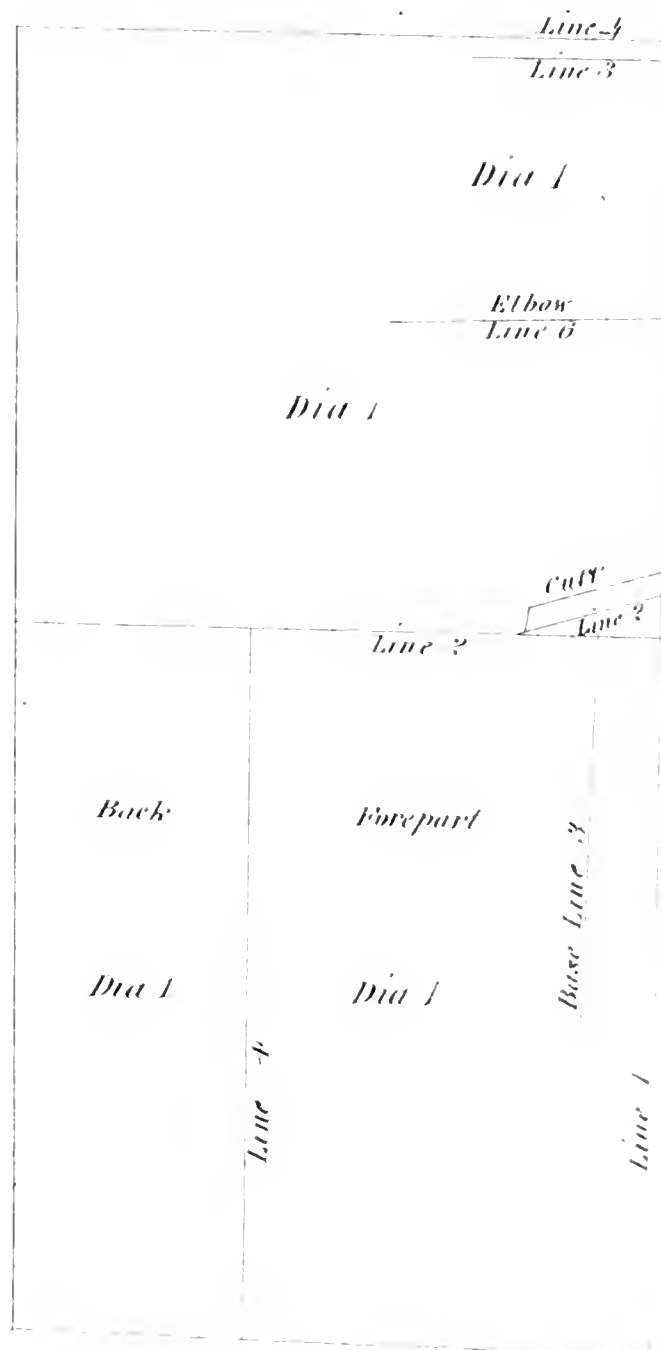
The following Diagrams will be more instructive, at the commencement, to any Cutter, than all the instructions that could be written in this book, or any other book, as all the points and lines are numbered in such a manner, as to show how to proceed from the first to the last in all parts of the draft ; and once the Cutter is proficient in one draft he will be proficient in all the drafts, from the twenty-two to the fifty inch draft, which are all the drafts that the gauge will accomplish, being twenty-nine in number for Coats, twenty-nine for Pants, and twenty-nine for Vests, thus affording a very large amount of valuable information, in comparison to any other work brought before the public heretofore.

When drafting by actual measurement, the coat should be drafted by the test measures for the length of shoulders, as some shoulders require to be raised and others lowered, according to circumstances, in order to fit the figure that the coat was measured for. The back should be drafted in the same manner by the test measures ; first, measure the whole length of back, then from the socket to line No. 3, for rise of back shoulder seam, and on to line No. 2, and test measure No. 3, or depth of seye on centre of back. There is also a test measure to prevent any unnecessary surplus of cloth at the top of side body seam. This measure is taken from the socket-bone close under the arm, and round to the pivot in front of seye. This measure can be dispensed with except in case of an extra erect or a shallow-backed person.

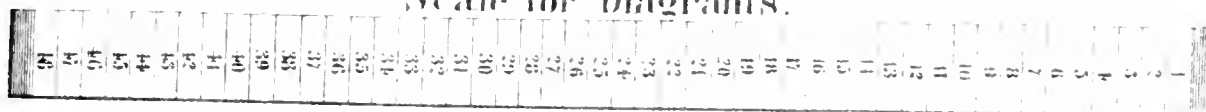
**DIAGRAM No. 1.**

Now we come to the Diagrams, which will be found, on examination, to be entirely different from any former system on the art of drafting, as being more intelligible, simpler, and easier to learn, yet perfect in all its points, while this system holds out the advantage of giving twenty-nine times more instructions in the art of drafting coats alone than any other system in the world, and the same number in Pantaloon, and in Vests, being equal to eighty-seven systems in all. All of those numbers or systems are combined into one grand system, one great principle. The man that can use one can use all, with the same perfection all through, which I claim to be the greatest advancement made in the art and science of tailoring for over a hundred years. All that I ask is to throw aside all prejudice, and give the system a fair trial, and it will convince the most sceptical that it contains all the merits claimed for it.

The first diagram, as well as the subsequent diagrams, is of the greatest importance to the cutter, as it is more instructive than all the words that can be put in writing in this work, or any other work on tailoring; in fact it is impossible to describe the art of drafting a coat in a simpler manner than what is done in this work. In the first place, before you begin to draft, smooth down the cloth, whether single or double fold, in all cases keep the selvage towards you, and the grain running to the left hand, and the web or cloth to the right hand, then commence to chalk off the selvage to the required length for the coat. Suppose the coat to be 30 inches long, add 1 inch more, which will be 31 inches in all from the bottom of the cloth, at 31 inches on the salvage line, No. 1, mark a point, and square across the cloth from side to side, call this line No. 2; then go back to line No. 1, and mark a point on line No. 2, at three inches, more or less, according to taste or fashion, from line No. 1; at this point, and parallel to line No. 1, draw base line No. 3, as shown on the diagram, then measure on line No. 1, from line No. 2, 24 inches for the sleeves, facings, &c., at this point square across from side to side, and cut off the cloth, or leave it on until you finish drafting the coat, this will be a little over one yard and a half cloth, 54 inches wide, and if wider, will take a less quantity; this will draft a coat 40 inches Breast, 35 inches Sleeve, and 30 inches long, and as a natural consequence smaller sizes will take less quantity of cloth in proportion to size, which every Cutter fully understands, without enlarging upon what quantity it takes to cut every size of garment required.

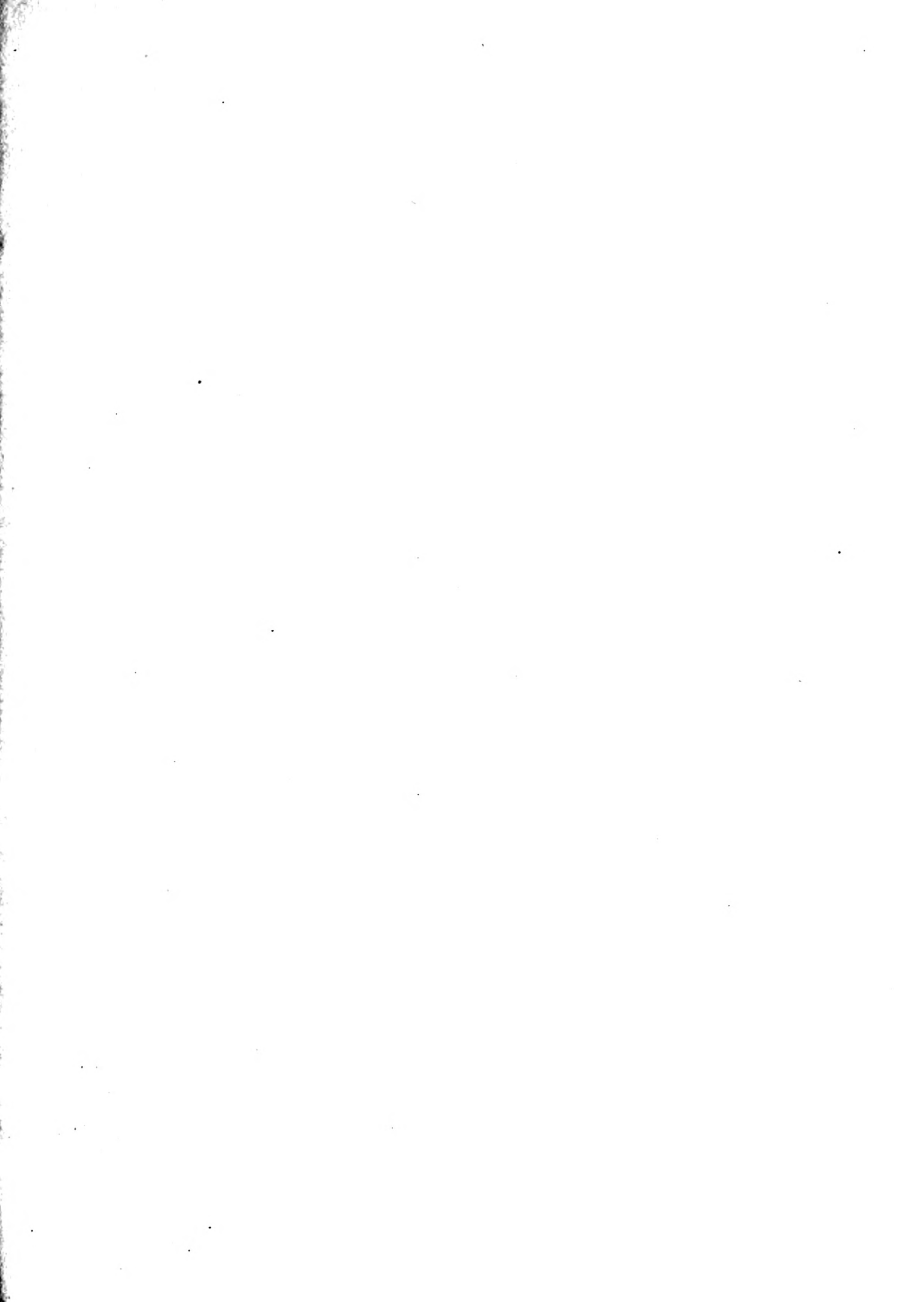


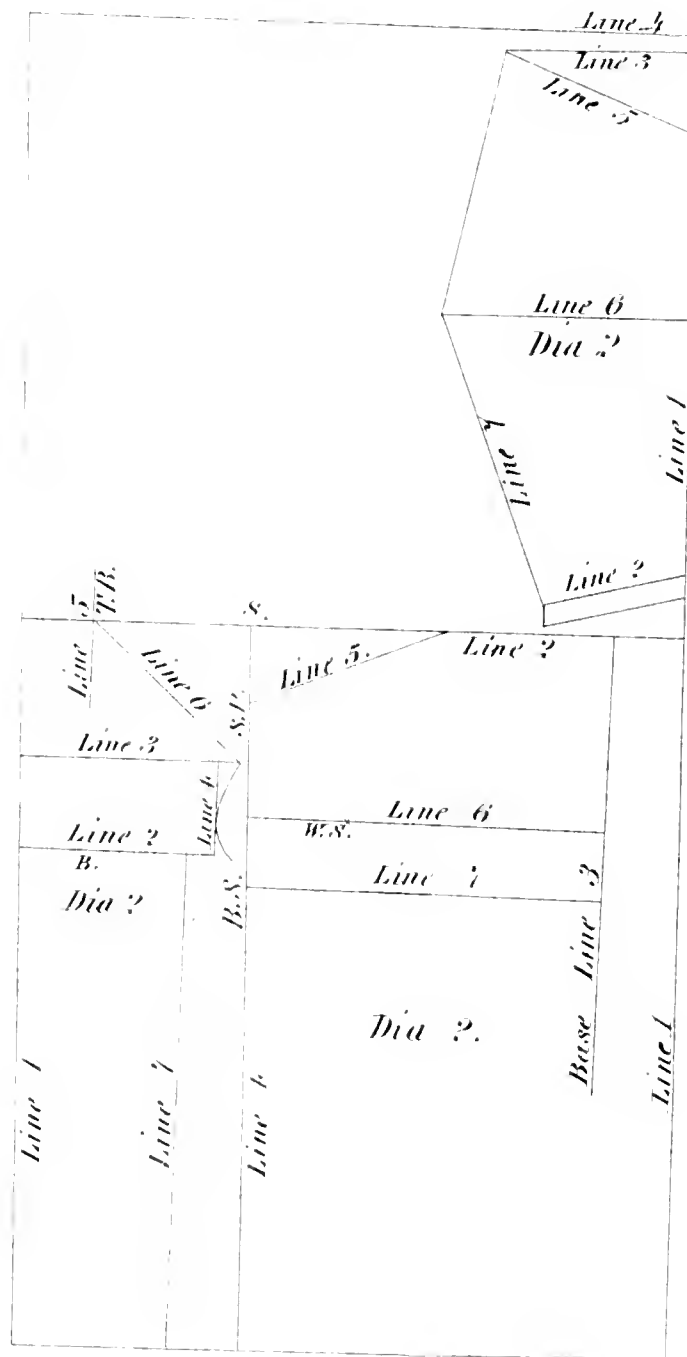
Scale for Diagrams.











**DIAGRAM No. 2.**

This diagram is the same as diagram No. 1, only in a more advanced state of perfection, being fully gauged and ready for drafting.

Suppose that you have diagram No. 1 before you, begin to gauge it in the following manner: First place the gauge on line No. 2, scale S, and 40 at base line No. 3, mark at the end of the gauge on line No. 2 point S., from point S. and at right angles to line No. 2 draw line No. 4; then place the gauge on line No. 4 at line No. 2, scales S.P. and B.S., mark both points, without moving the gauge, at 40 on each scale; then mark a point one-third of the distance from point B.S. to point S.P., and draw lines Nos. 5, 6, and 7, as shown on the diagram. Then on line No. 6, scale W.S., mark point W.S., and then mark a point one-third the distance from line No. 7 to line No. 6,—this point is for the top of side body seam. This concludes all the points and lines of the fore part of a sack coat.

I would recommend all new beginners in the art of cutting to draft all the points together, before proceeding any further, as it will appear simpler and be better understood by the uninitiated in this form.

Having the fore part drafted, proceed with the back as follows: Draw a line from the top of side body seam to the folded edge of the cloth, and at right angles to the folded edge; if there is a centre seam in the back call it line No. 1 in either case, and the preceding line No. 2; then place the gauge on line No. 1, or folded edge, at line No. 2, scale S.H., at 40, mark a point at the brass tips for line No. 3; then draw lines Nos. 3 and 4; then mark a point at four to five inches up from line No. 3 on line No. 1; then place the gauge on line No. 1, mark at 40 scale T.B., and draw line No. 5 for top of back; then draw line No. 6 for back shoulder seam, to desired rise of back, which must be guided by the width of shoulder seam; then draw line No. 7, 1 to  $1\frac{1}{2}$  inches less than the width of the back. This concludes all the points and lines necessary to draft a back with. But before proceeding any farther, draft in all the points of the back.

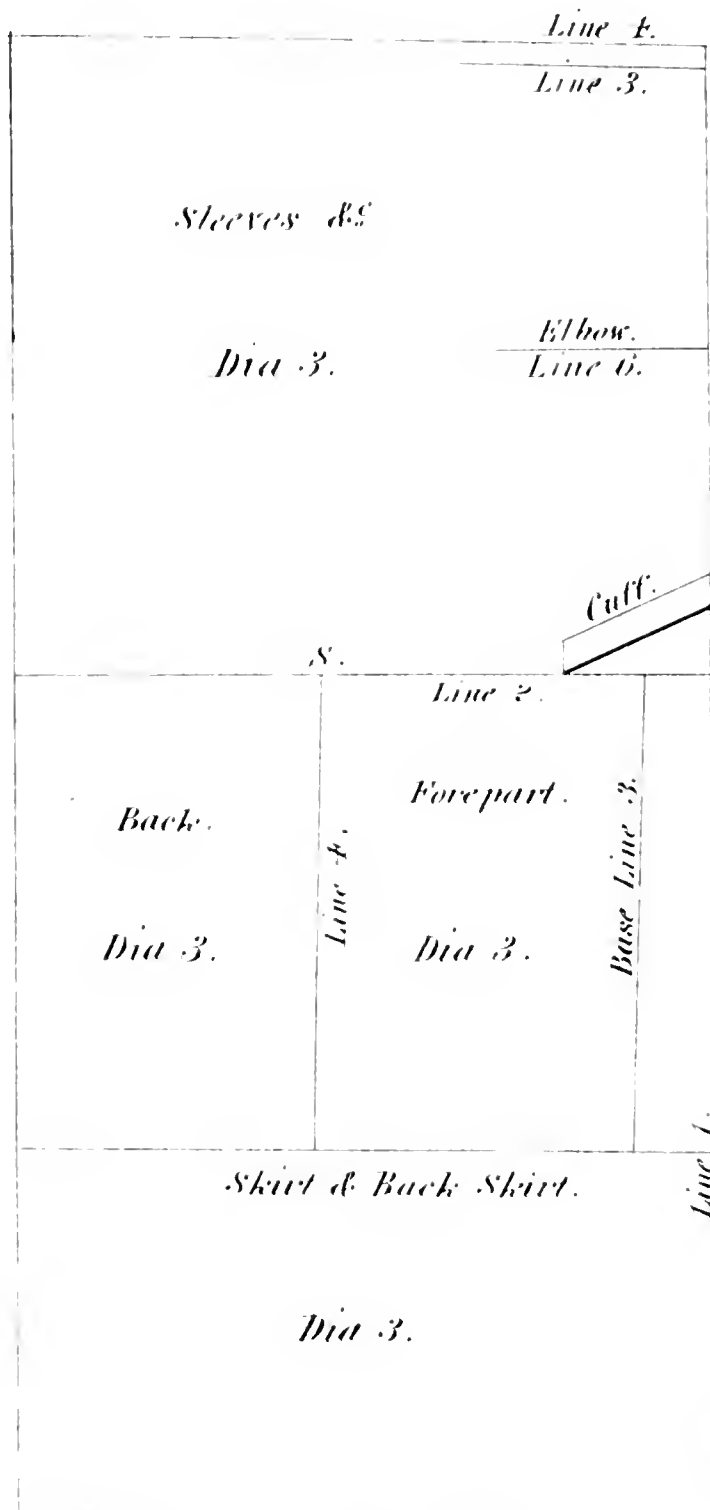
Now proceed with the sleeves in the following manner: Go back to the selvage line No. 1, make this line No. 1 your base for the front seams of the sleeves; first mark the two cuff lines No. 2, then take tape measure at  $8\frac{1}{4}$  inches, or the width of the back as the case may be, and place on the lower cuff line and on line No. 1; then measure up line No. 1 and mark point for elbow; then to the head or line No. 4, then mark point S.H., scale S.H. at 40; draw line No. 3, 1 to  $1\frac{1}{2}$  inches from line No. 4; then draw line No. 5; then make line No. 6, mark a point for elbow and draw line No. 7, and draft in the points and lines, and the sleeves are finished—the lower part being always drafted by the upper, as shown in the annexed diagram.

Collars are drafted quite simply, and easily learned. First draw a line on any piece of cloth that is two to three inches wide and about nine inches long; cut it off and fit in the gorge to the desired size and shape, mark and cut it off; this part will be half of the under collar. Cut the upper by the under collar. This is the only true method for cutting a collar by which it will fit a high or low gorge.

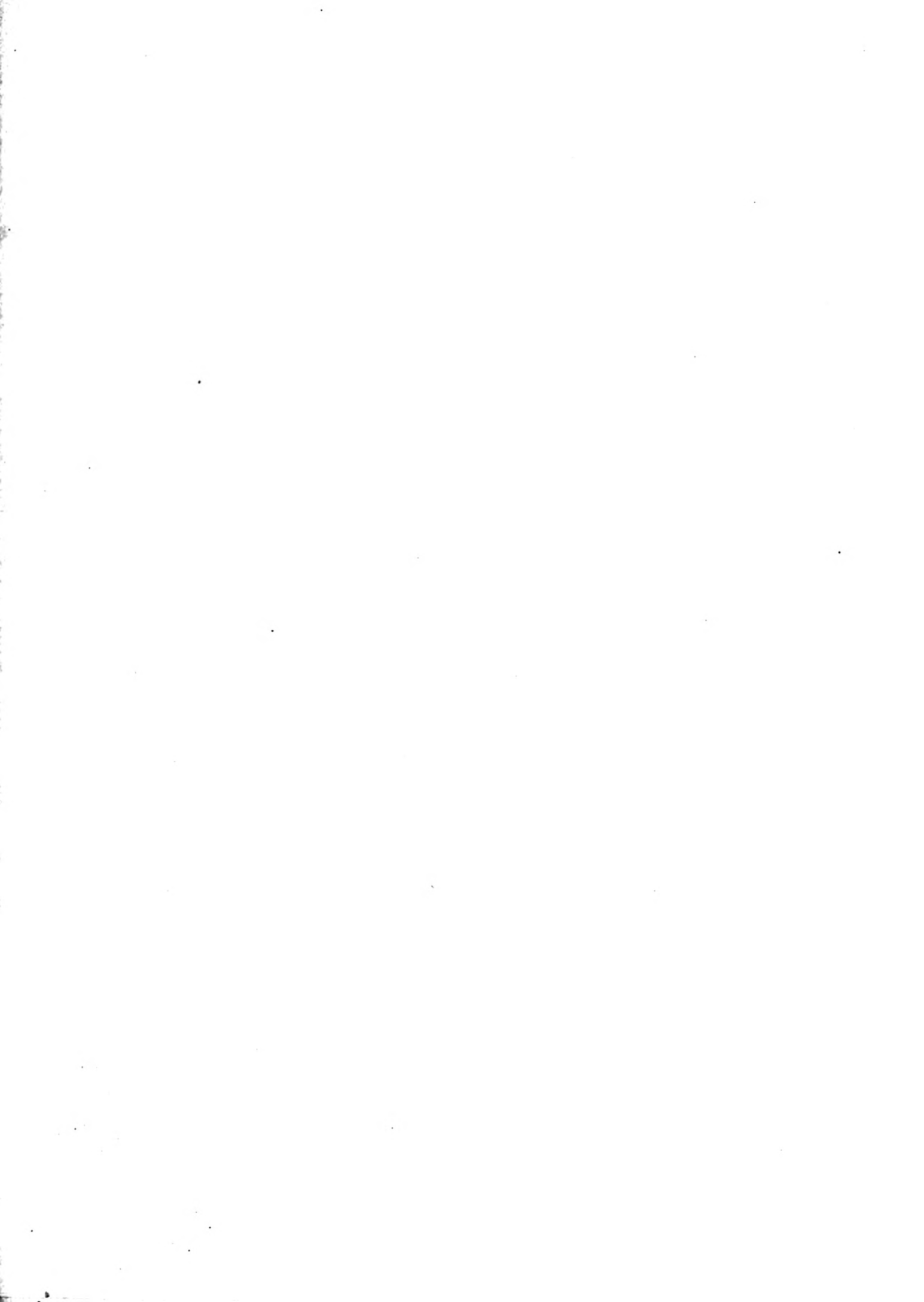
This concludes the draft of all parts of a Sack Coat. For flap and welts refer to the diagrams for further information.

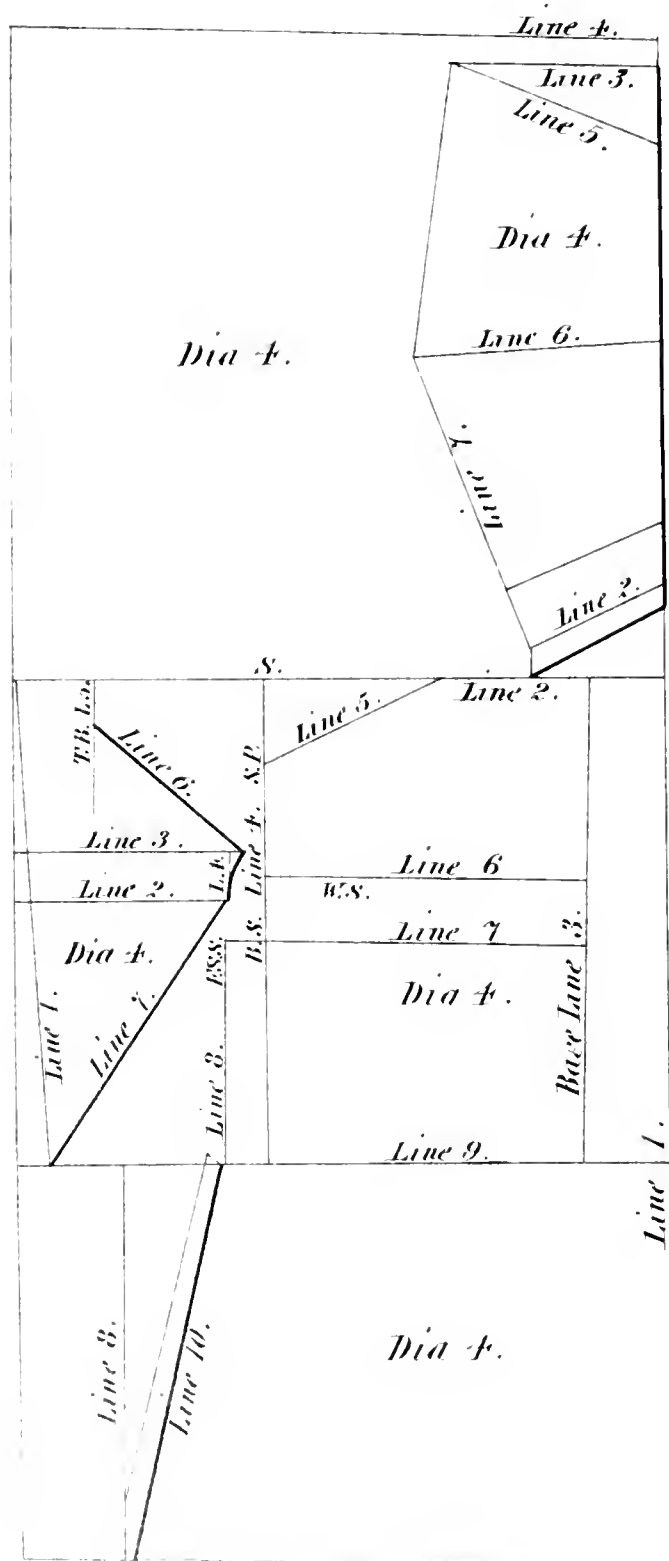
**DIAGRAM No. 3.**

This Diagram is for a Frock Coat, and in its general outlines and principle is the same as Diagram No. 1, except that it is in four parts instead of three, as in Diagram No. 1, the additional part in this Diagram being the skirt. Suppose you are going to draft a coat 34 inches long, add 2 inches, which will be in all 36 inches, and divide in the following manner: measure 15 inches from the bottom upon line No. 1, mark point, and square across the cloth from side to side; then, from the line that you have just drawn, measure 21 inches upon line No. 1, and square across as before from side to side, this is line No. 2; then measure three or more inches from line No. 1 for base, and draw at right angles to line No. 2; then place the gauge on line No. 2, at 40, Scale S, and mark point S, from point S, at right angles with line No. 2, draw line No. 4; then measure from line No. 2, on line 1, 24 inches for the sleeves, and draw a line at this point across the cloth from side to side, this concludes all the lines for this diagram, which will be easily understood by referring to the diagram.











**DIAGRAM No. 4.**

This Diagram is the same as diagram No. 3, only being in a more advanced state of perfection, being fully gauged and ready for drafting.

Then suppose that you have diagram No. 3 before you, begin to gauge in the following manner: first, place the gauge on line No. 4, at line No. 2, Scale S.P. and B. S., mark both points without moving the gauge at 40, on each scale, then mark a point one-third of the distance from point B.S to point S.P., then draw lines Nos. 5, 6, and 7, draw the latter line three or more inches over line No. 4, then place the gauge on line No. 7, at 40, on base line, scale F.S.S., and mark point F.S.S., and draw line No. 8 at right angles with line No. 7, then place the gauge on line No. 6, scale W.S., mark at 40, point W.S. This concludes all the points and lines of the fore part. I would recommend all new beginners in the art of cutting to draft all the points together before proceeding any farther, as the draft will be understood better after all the points are closed.

Then proceed with the back as follows: Continue line No. 6, on the fore part, to the folded edge of the cloth, the same as line No. 9, then draw line No. 1 and mark a point at two to three inches above line No. 2; then draw lines Nos. 3 and 4 and mark a point from four to five inches from line No. 3 on line No. 1; then place the gauge on line No. 1, scale T.B., at 40 mark point T.B., and draw line No. 5 for top of back; then draw line No. 6 for back shoulder seam to the desired rise on line No. 5, as the back must be guided by the width of shoulder seam; then draw line No. 7, and draft in all the points of the back and back skirt, and that finishes the back and back skirt.

The sleeves are drafted in this and succeeding diagrams in the same manner as in diagram No. 2, only the sleeves of a body coat should be smaller than those in a sack coat. But sleeves at all times should be governed according to the fashion, whether small or large.

Collars for all coats ought to be drafted as explained in diagram No. 2. Although collars differ much in appearance according to the style of coat as well as the Fashion yet the theory is at all times the same, and if adhered to, the rule laid down in diagram No. 2 will never fail in producing a well-fitting collar in every case, whether for a high or low gorge, the effect will always be the same.

**DIAGRAM No. 5**

Represents a very popular and nobby business Sack Coat, and shows two kinds of front—the square and the rounded. This coat is worn at all seasons of the year, and has been for many years and still is worn, in one shape or another according to the style of fashion, by the majority of all classes of people. It is made from all kinds of material in cloth, from the ordinary every-day tweed to the finest black, blue, or brown broad cloths, and seems to be a permanent institution. The diagram shows the manner the coat is drafted in by this system, and the different points from which it is drafted ; although not numbered, as in the former diagrams, still the principle of the system is quite perceptible, and must be easily understood by any person of the slightest intelligence. The diagram also shows the manner the coat is drafted from the cloth, and the quantity of material it takes to draft a coat of this kind—being a trifle over a yard and a half, if the cloth is of the usual standard of fifty-four inches wide, if wider it will take a less quantity. The edges are made up in all styles according to fashion—bound and unbound, single and double-stitched edges, and sometimes bluff edge. When made from fine material, this coat looks very neat with a velvet collar, whether fashionable or not ; although I am not an advocate of anything that is not fashionable, neither do I think anyone else ought to be, if he has the slightest apprehension of succeeding in business.

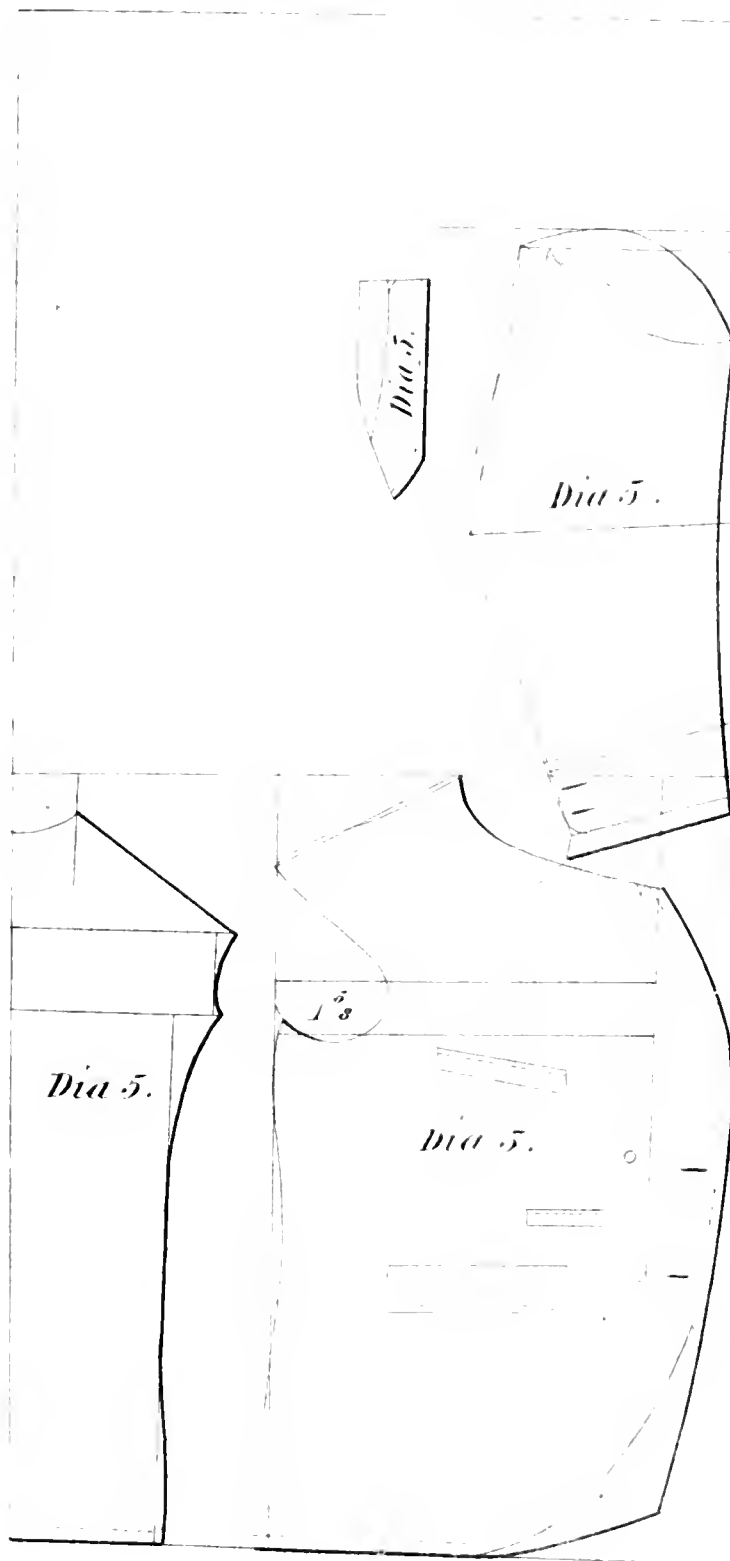


DIAGRAM N<sup>o</sup> 5.  
MADE UP.

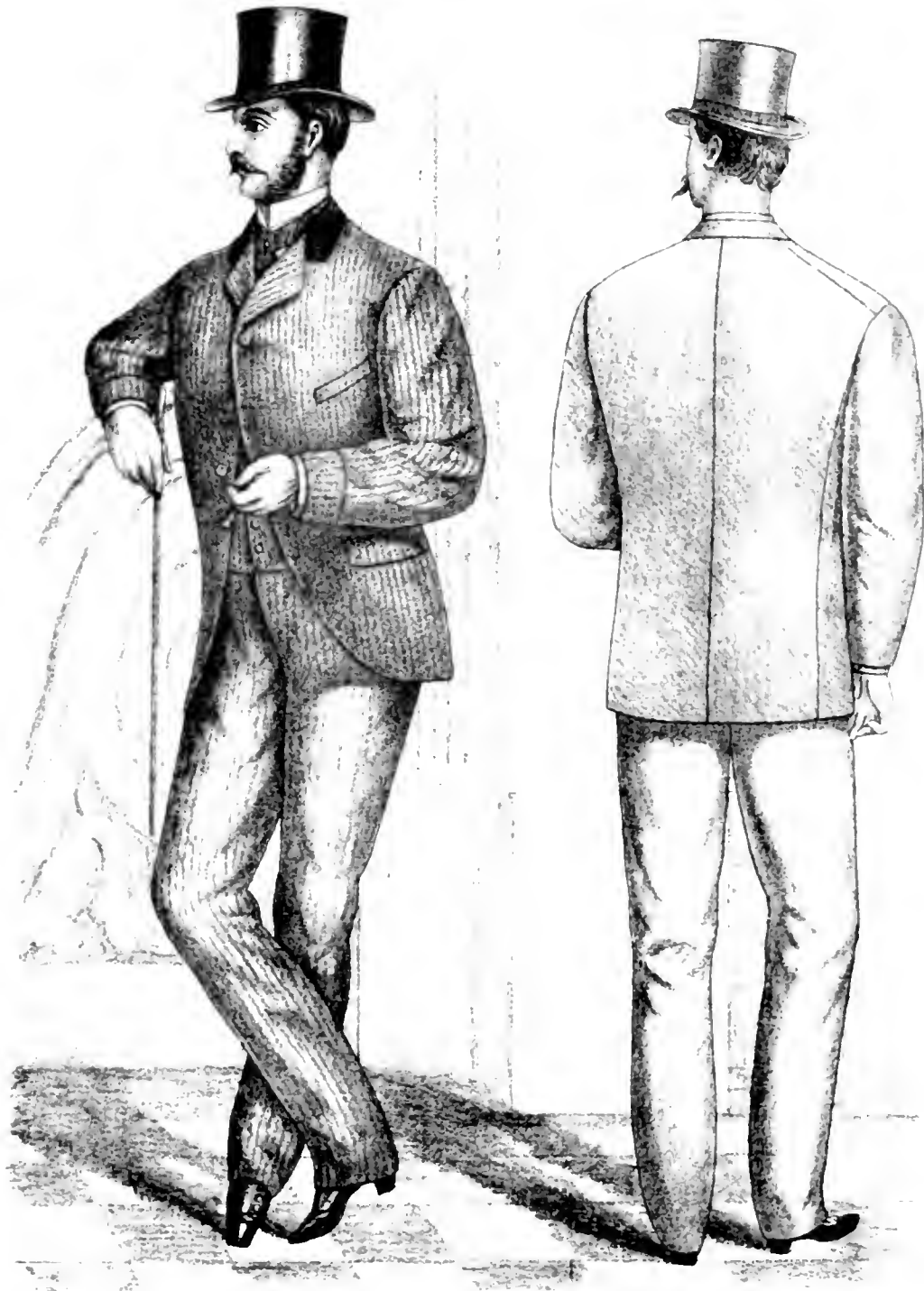
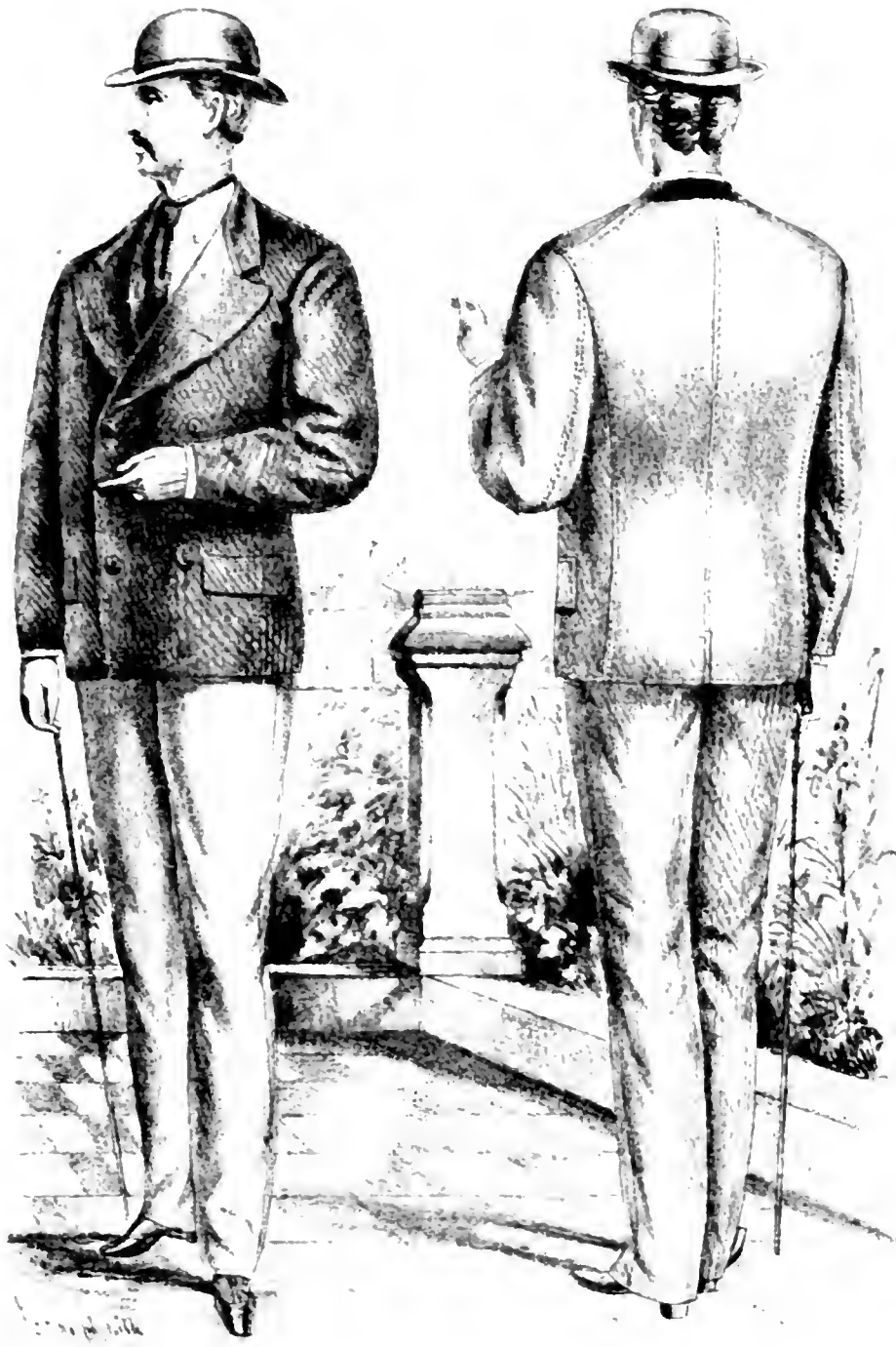
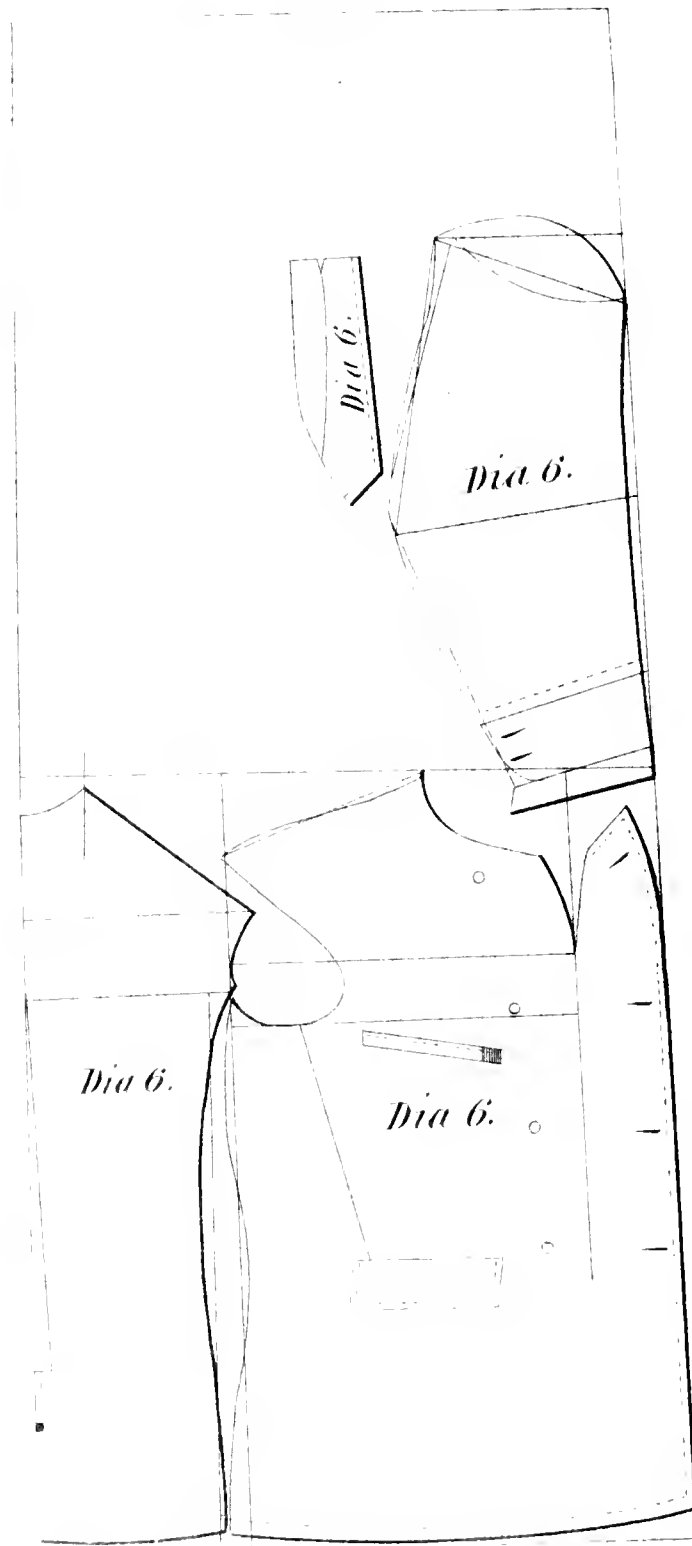


DIAGRAM N<sup>o</sup> 6.  
MADE UP.





## DIAGRAM No. 6

Represents a Double-breasted Sack Coat, the great American Pea Jacket, or the English Reefing Jacket, that braved the battle and the breeze for a thousand years ; or the invincible Skating Jacket of the Canadian Boreas ; this coat differs in its general appearance, according to the country that it is made in, at all events it is a very comfortable and serviceable garment in cold weather, and at all times for a sea-faring man. It is made from pilots, beavers, and all kinds of heavy material ; it is made with binding and without binding, according to the quality of cloth and the taste of a customer, or the style of fashion. A coat of this kind will take from one yard and a half to one and three-quarters cloth, usual width 52 to 54 inches. All such coats ought to be lined through the body with Light Tweed, or some other heavy material to match ; the sleeves should be lined with fancy flannel or fine winey, strong jean pockets, good heavy canvas padded firmly through the breasts and shoulders, and well stayed all round, in order to maintain its original shape so long as it is a coat. This is, or ought to be the most durable coat made, as being made from the heaviest and stoutest material, and there is no doubt, if made properly, that it will give abundance of wear to whoever may require such a garment.

## DIAGRAM No. 7

Represents the great French *par excellence de Paris* Coat. This was originally a French Coat, but since its advent to England and America, it has been designated by other names, and changed from its original appearance to suit its adopted countries. It is now made in single and double breast, although its original form was double-breasted ; at all events it is one of the most nobby coats made for every day wear, and at one time was a leading garment, and is still very much worn in an altered state, and under some other assumed name from time to time. This Coat is usually made from fine material, such as fine Tweed, Diagonals, Silk Mixtures, Meltons and Broad Cloths, and when well cut and made looks very stylish. Such a coat should be lined in the body with alpaca, lustre, or Italian cloth, sleeves ought to be lined with fine muslin of fancy colour, or a good quality of soft salicia, French elastic canvas of good quality, padded lightly, but firm, through the breast and shoulders ; edges, pockets, and tacks well stayed before put together, the edges made up according to fashion, bound or stitched as the case may be. This coat will take about the same quantity of cloth as the latter one in cloth of the same width, but, if wider, will take less quantity. The shoulders of this coat should be cut broader than in the walking coat, and built in the same manner as shown on Diagram, No. 40 ; if not, the appearance of the coat will be killed, and will look like nothing in its general bearing, without being cut, as described here.



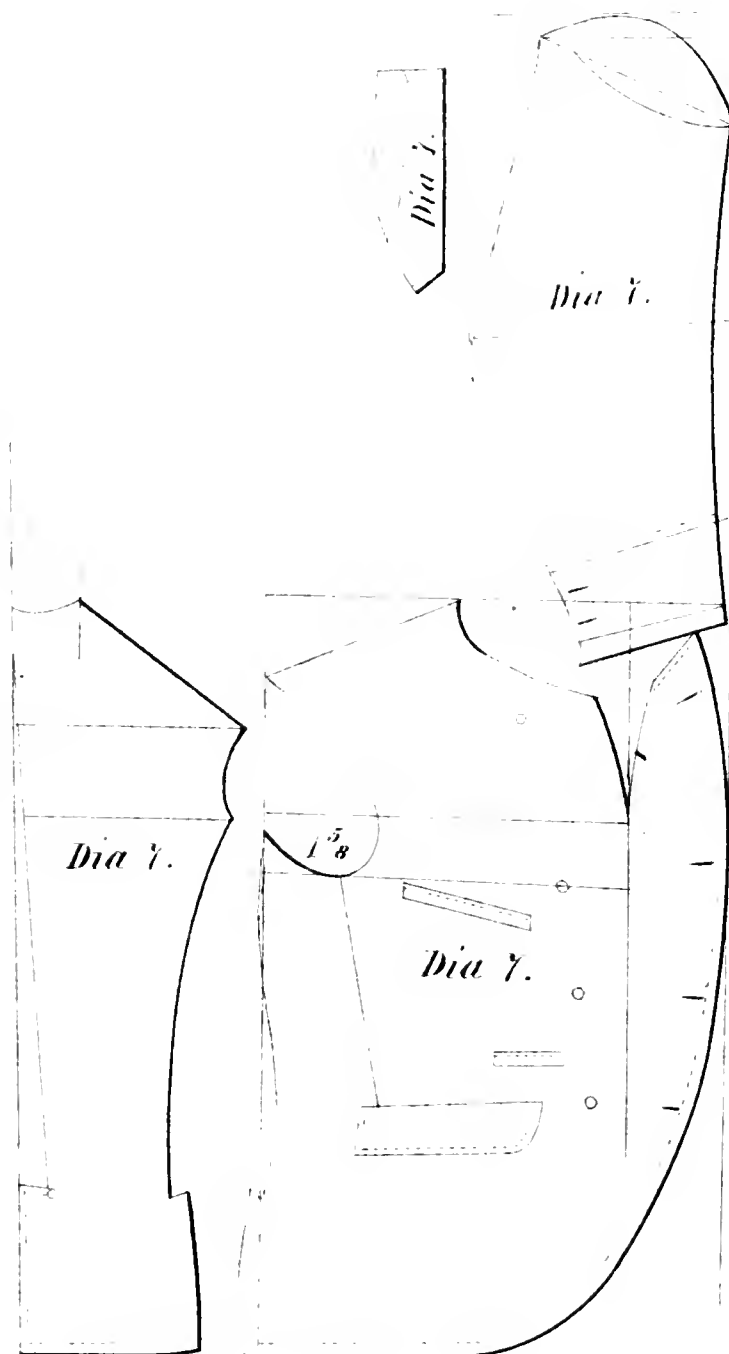


DIAGRAM No 7.  
MADE UP.

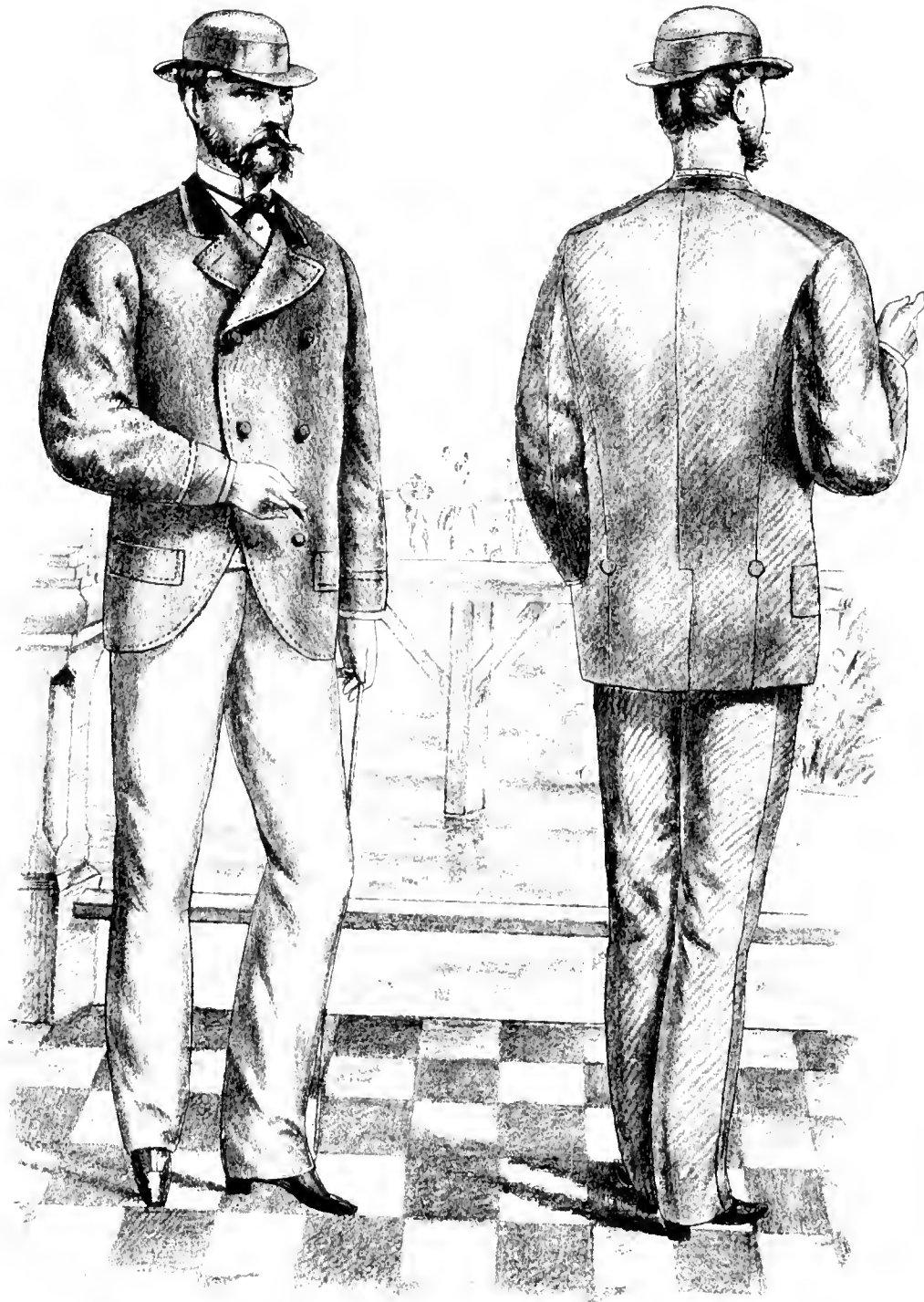
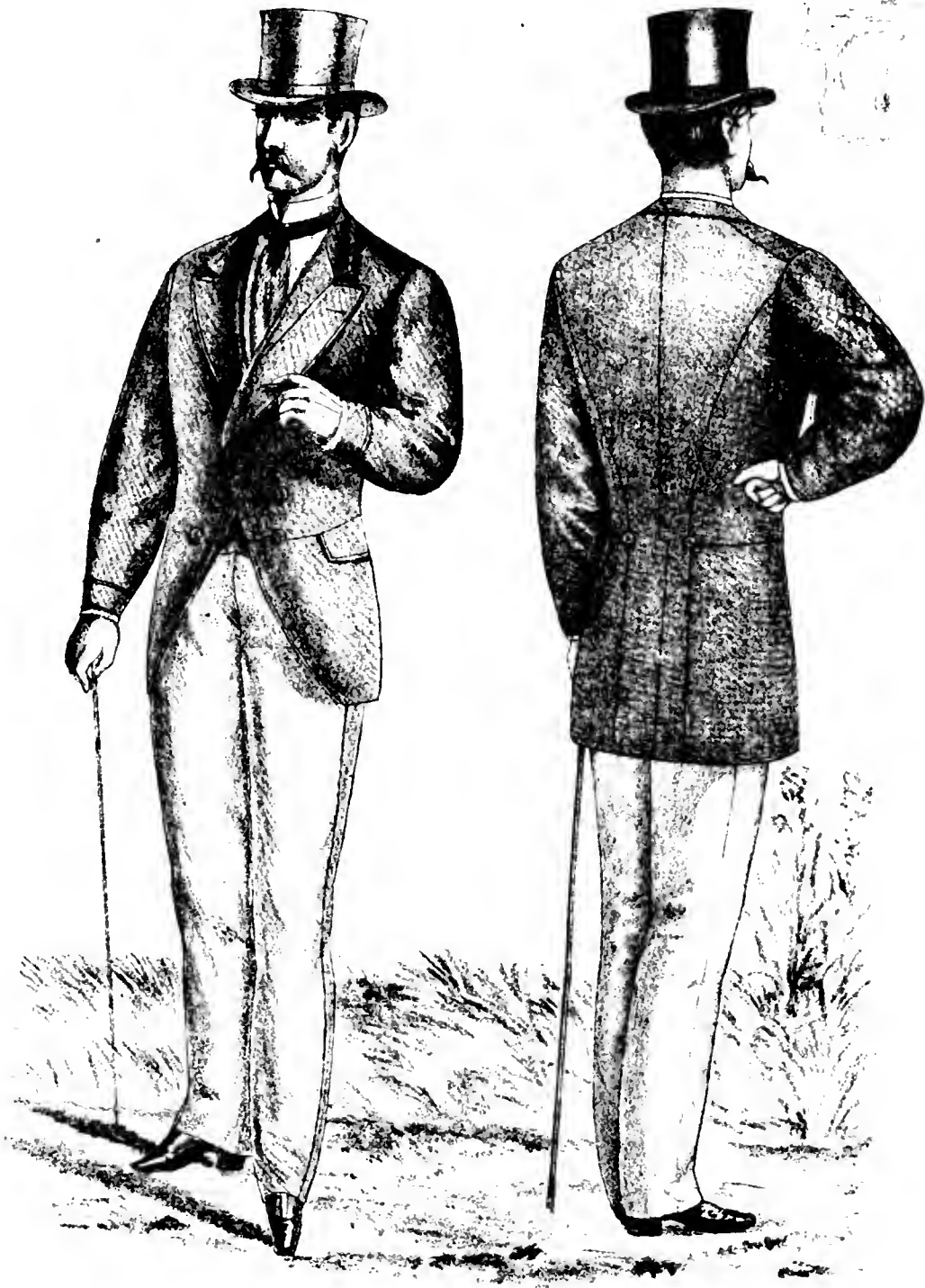
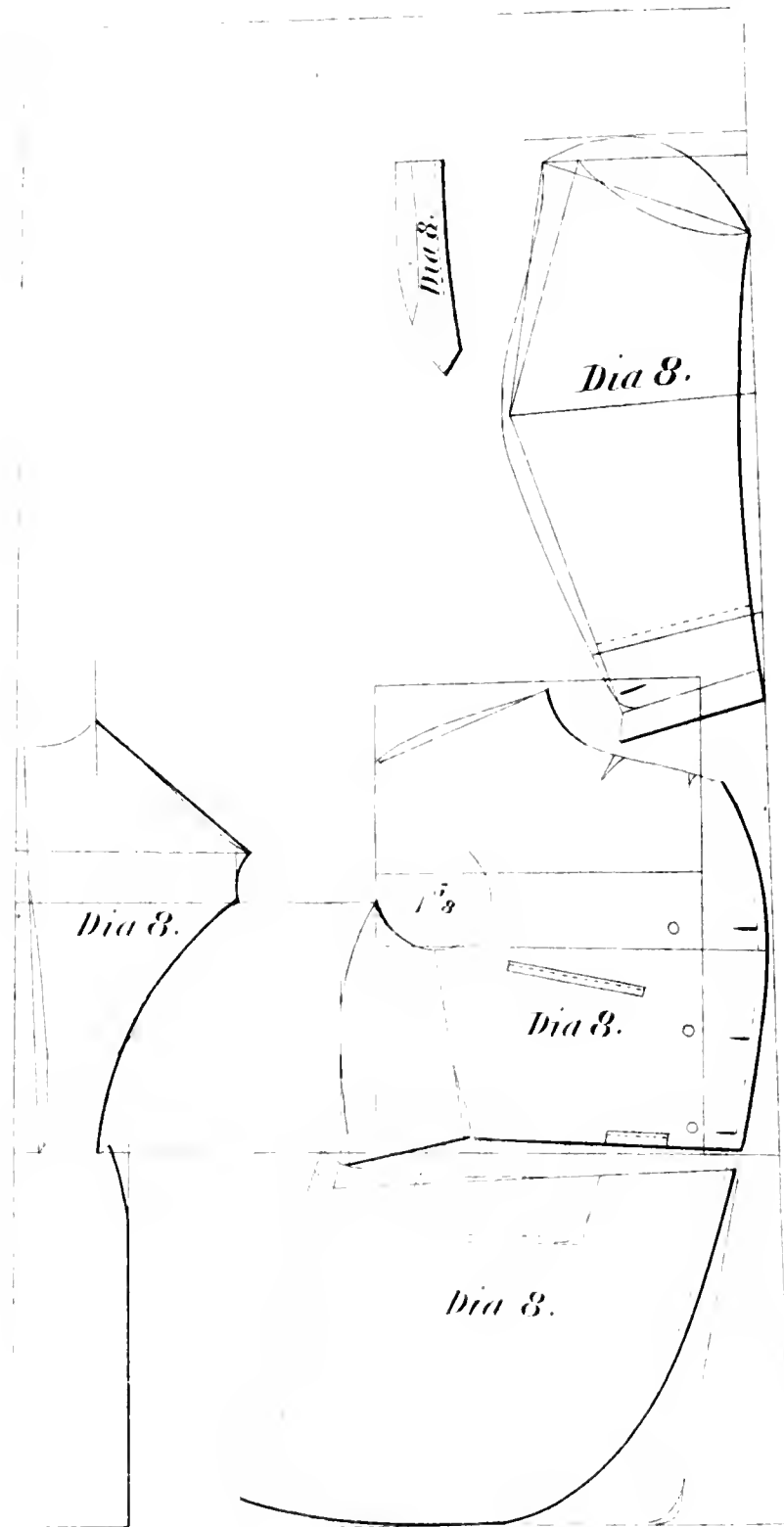


DIAGRAM No 8.  
MADE UP.





## DIAGRAM No. 8

Represents a Business Coat, and is a permanent garment for all time to come, in some shape or other. This style of coat is generally worn by professional and business men during business hours, from whence it derives its name. It is made from various kinds of material, but generally from fine cloths; although in the winter season light beavers, chevots, &c., are used for this coat. It will take a trifle over a yard and a half of cloth of the usual width (fifty-four inches). The skirt seam ought to be cut plain, or rather inclined to rounding at the back part of the seam, in order that the skirt may hang smooth and plain, which is very becoming in a garment of this kind. This coat, like all other close-fitting garments, ought not to be padded too much, except where it is necessary. Trim in the same manner as the last diagram, and be sure that the canvas and padding are properly fastened to the shoulder seam and fore seye. If this is attended too, the coat will maintain its original appearance to the last. The diagram shows the manner the coat is drafted from the cloth; also the rule as applied to the cloth, not in this diagram only but in every other in the work. The collar of a coat of this make should be a trifle narrower and somewhat curved on the outer edges, so as to lay or spread out gracefully on the shoulder. When the gorge is short and the lapel narrow, the collar must naturally be shorter and straighter in all such cases.

NOTE.—Line No. 2 on the back, should be a continuation of line No. 6 on the fore part, when the side body is drooped down below line No. 9; not otherwise. But it depends upon the make of the customer, whether he is long or short backed; in either case it can be drafted with ease.

This Coat is made Single and Double-Breasted, with and without lapels, and with flaps and pockets on the skirt, and sometimes with pockets in the back, but at all times according to fashion.

**DIAGRAM No. 9**

Represents a Walking Coat, or what is generally termed a Half Dress Coat. This garment is worn by all classes of people as being more convenient and less expensive than a Frock Coat. This coat was originally intended by its inventor to be made only from fine cloth, which is not adhered to now-a-days to any extent; however, it makes a very nice and dressy garment. When made from fine black, blue, brown, or any other plain colored cloth, this coat will take about one yard and three-quarters cloth in its usual style, but sometimes less, as it depends altogether on the length of the cut. It requires the greatest pains in building a garment of this kind—almost as much as a Frock Coat, in fact it is the nobbiest coat of the two. The trimmings ought to be of the best quality satin cloth or silk serge for lining, sleeves should also be lined with fine cambric or silk, French elastic canvas and hair cloth through the shoulders and breast, padded between with two ply wadding; the canvas and hair cloth ought to be shrunk before it is padded, this ought to be done in every case. This coat ought to be built inside on the same principle as a Frock Coat. It changes in style, according to fashion, like every other garment from time to time. In this diagram I shall endeavour to explain the different effects in altering the sleeve heads; according to the system the sleeves will fit a figure of good proportions, but if he should stand very erect and inclining backwards, and full in the chest, then reduce point S.H., and lengthen line N. 5, this will increase the rounding of sleeve head and place the inside sleeve seam further back from view. By reversing the same operation, a stooped or round-shouldered figure can be fitted in the same manner.

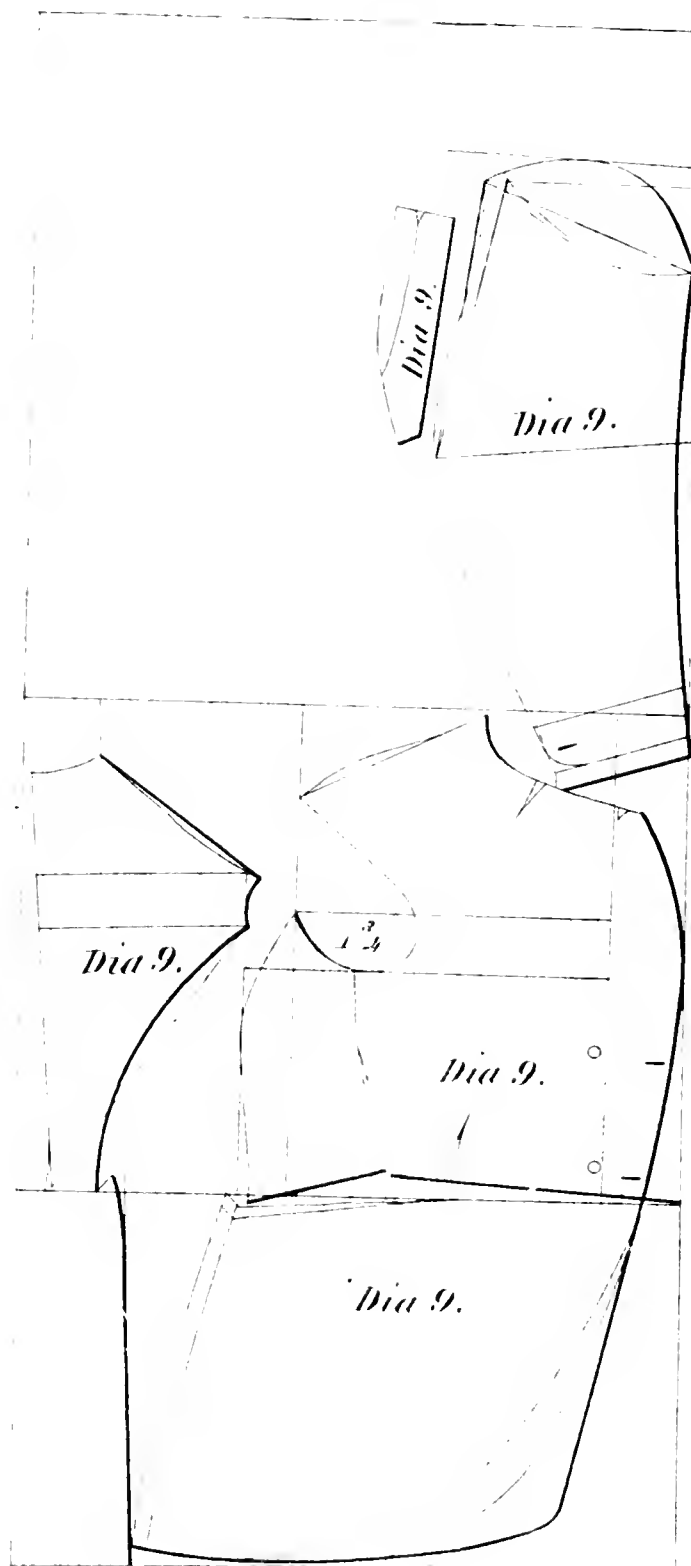


DIAGRAM N<sup>o</sup> 9.  
MADE UP.

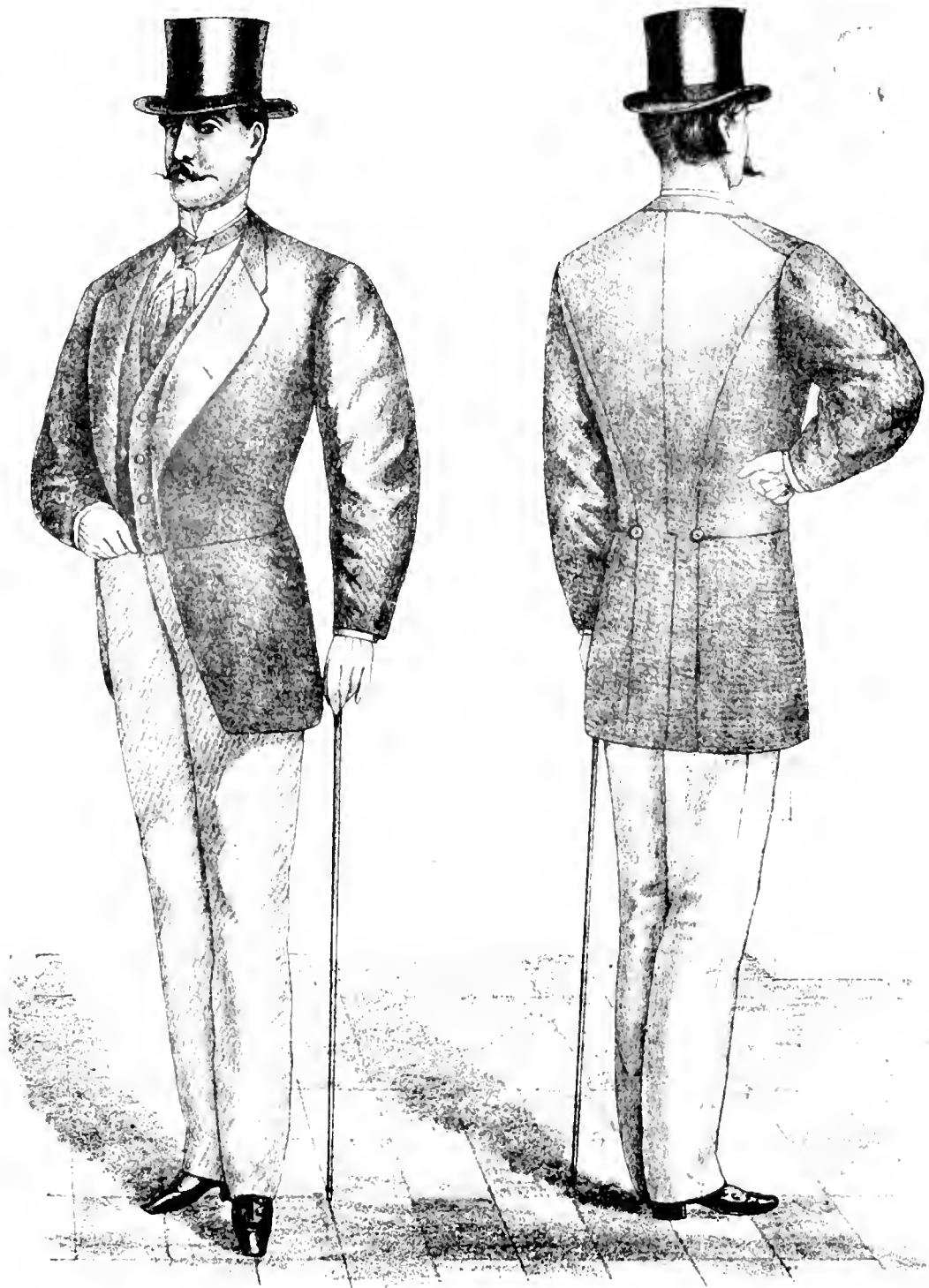
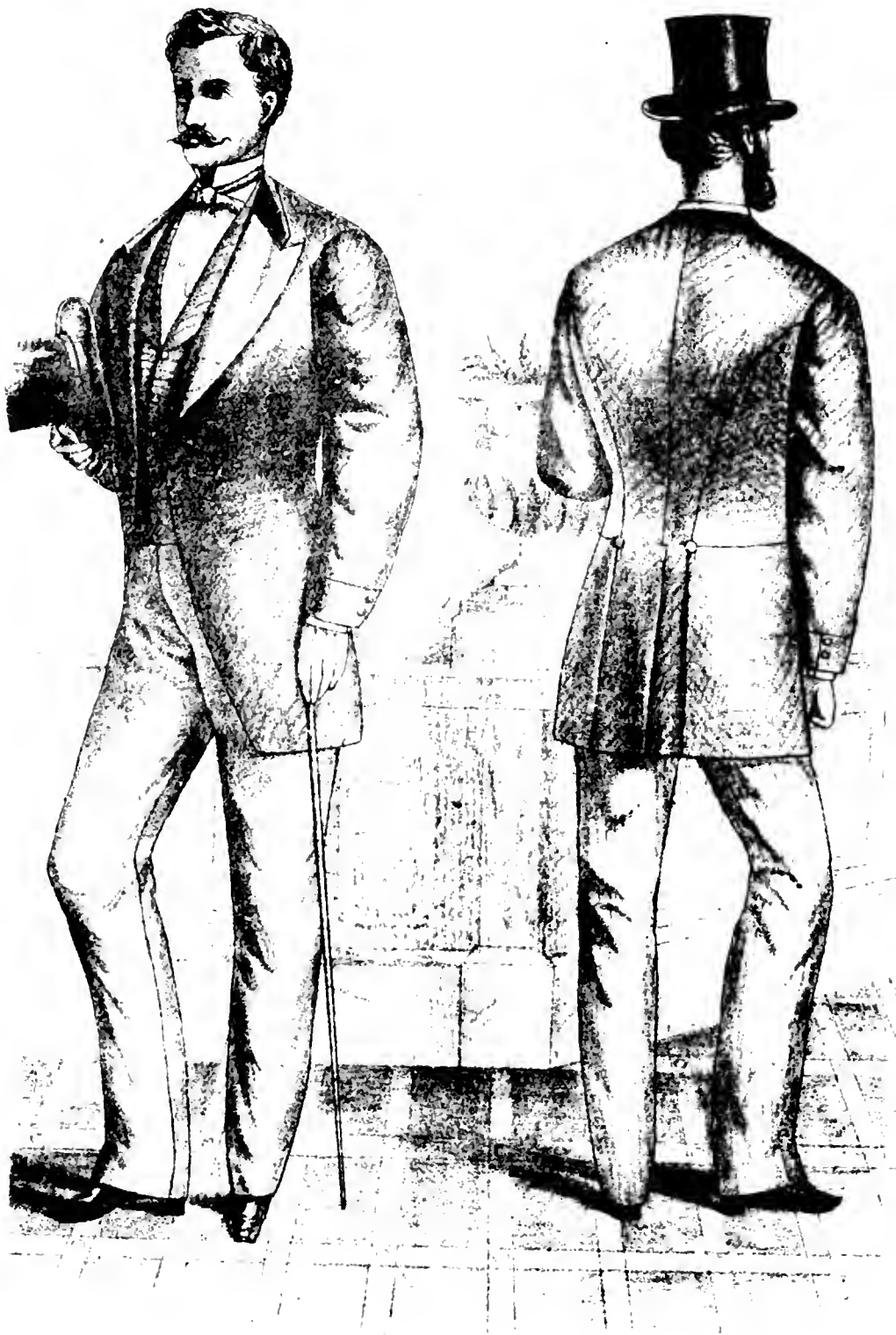
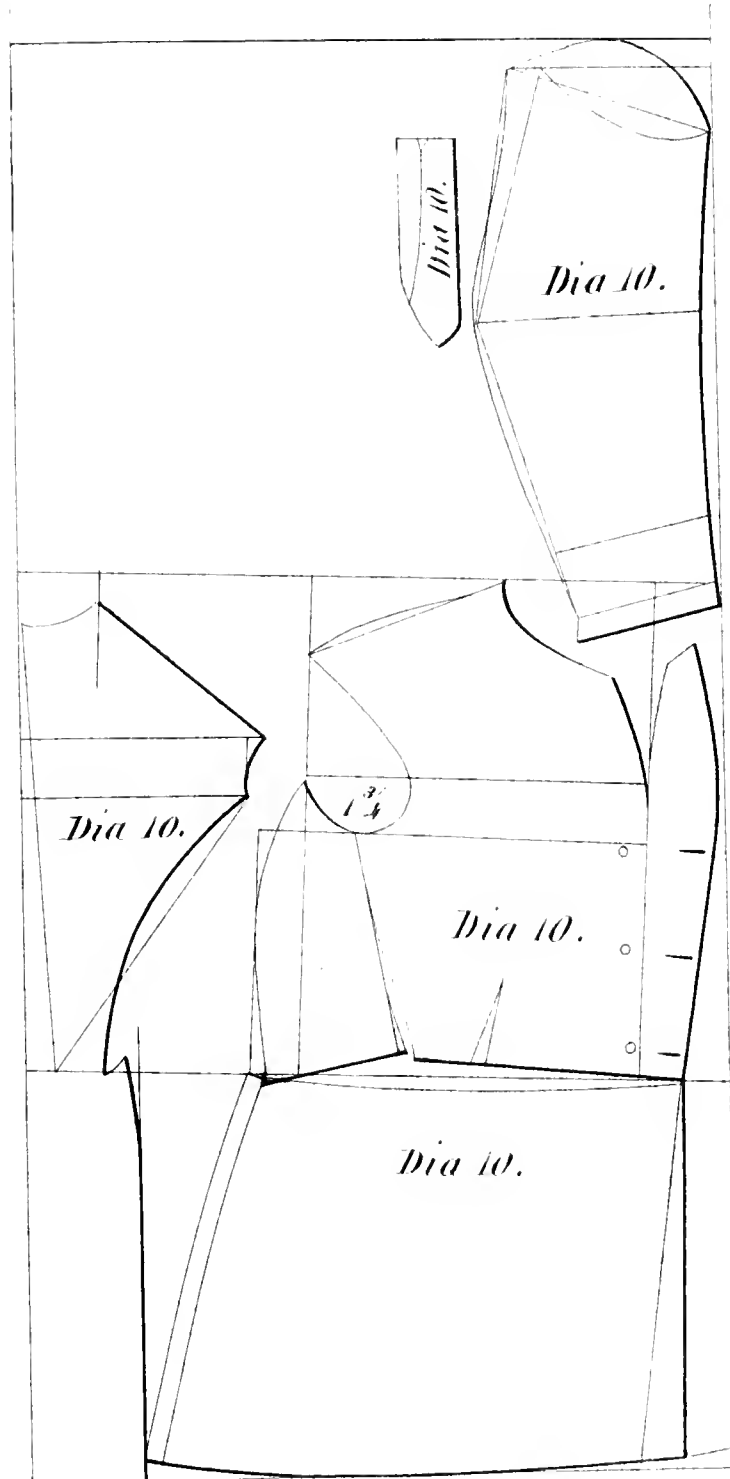




DIAGRAM No 10.  
MADE UP.





**DIAGRAM No. 10**

Represents a Single-Breasted Frock Coat, and is in many respects similar to the last diagram. The lapels are pointed, but not cut off as in the Double-Breasted Coat, and the skirt is square or near it, but sometimes transverse and a little rounded off ; but at all times it ought to be according to the fashion of the day. This coat is only made from broad cloth, black, blue, brown, and plain coloured goods ; it would not suit in any fancy material, as it is intended exclusively for a dress, or rather Half Dress Coat, and looks well when cut properly, trimmed and made first class. It will take one yard and three-quarters cloth to cut such a coat. The trimming to be the same as the walking coat. In all dress or close-fitting coats the fore scye ought to be stretched so as to let the arm come forward without showing any wrinkles at the scye or on the fore part, and at the same time it will give greater ease to the arm ; while this is being done the side body scye, and back scye ought to be surged with silk to prevent them from stretching while the sleeves are put in. All the diagrams in this work are based on well proportioned figures, and, as every cutter is well aware, that a well proportioned garment will not fit every one, therefore it is quite indispensable that every cutter ought to know how to apply the rule to any figure whether well proportioned or not. For instance, take a figure that is about the same size at the waist that he is at the chest, in that case you must extend the side body over line No. 8 to the required size, and by so doing you will find that the coat will fit as well as it would if cut by the system for a well proportioned figure. At the same time, while you are extending the side body seam, you must place back the side body centre seam in proportion to what you have extended the other seam. The breast system is a never failing rule ; for fitting the chest, whether for a slim or a stout figure : neither is the waist if applied as described or laid down here.

**DIAGRAM No. 11**

Represents a Double-breasted Frock Coat—the coat of coats. This coat has been from time immemorial the leading garment, and will be to the end of time, in some shape or other. It is only made from the best material, or ought to be so, in black, blue, or brown, &c.. The trimmings for a coat of this kind should be of the very best, such as silk serge or fine Italian cloth, for body and skirt linings; sleeves lined with plain or a small pattern silk of good quality to match the other linings; French elastic canvas and hair cloth, padded with two-ply wadding through the breast and shoulders, shrunk and shaped to match the outside before being put together, and then firmly fastened to all the seams in the proper places, in order that the coat may maintain its original shape so long as it is a coat. Every cutter and tailor ought to endeavour to keep up the reputation of this garment, as being the leading coat made by the profession. There is no difference between the frock and dress coat, except in the skirt, which will be explained more particularly hereafter. The frock coat will take one yard and three-quarters to two yards of cloth, and a dress coat a yard and a half; cloth the usual width (fifty-four inches), if wider, it will take less quantity to make a coat. The fore part, or the breast and shoulders, is the most important part of a coat of this kind. At all times, and in every case, the shoulder points are the most important parts of the coat, and if not located in their proper places will be sure to throw the coat out of balance. To obviate this daily occurrence with the majority of cutters, this system is so arranged in its construction and test measures, that it is impossible to cut a coat for any figure whatever that will be out of balance. It would emphatically be an absurdity to entertain such an impression, at all events with this system; based as it is on principles of science and common sense. Trying on garments, and cutting paper patterns for the figure to be fitted, is a thing of the past with this system.

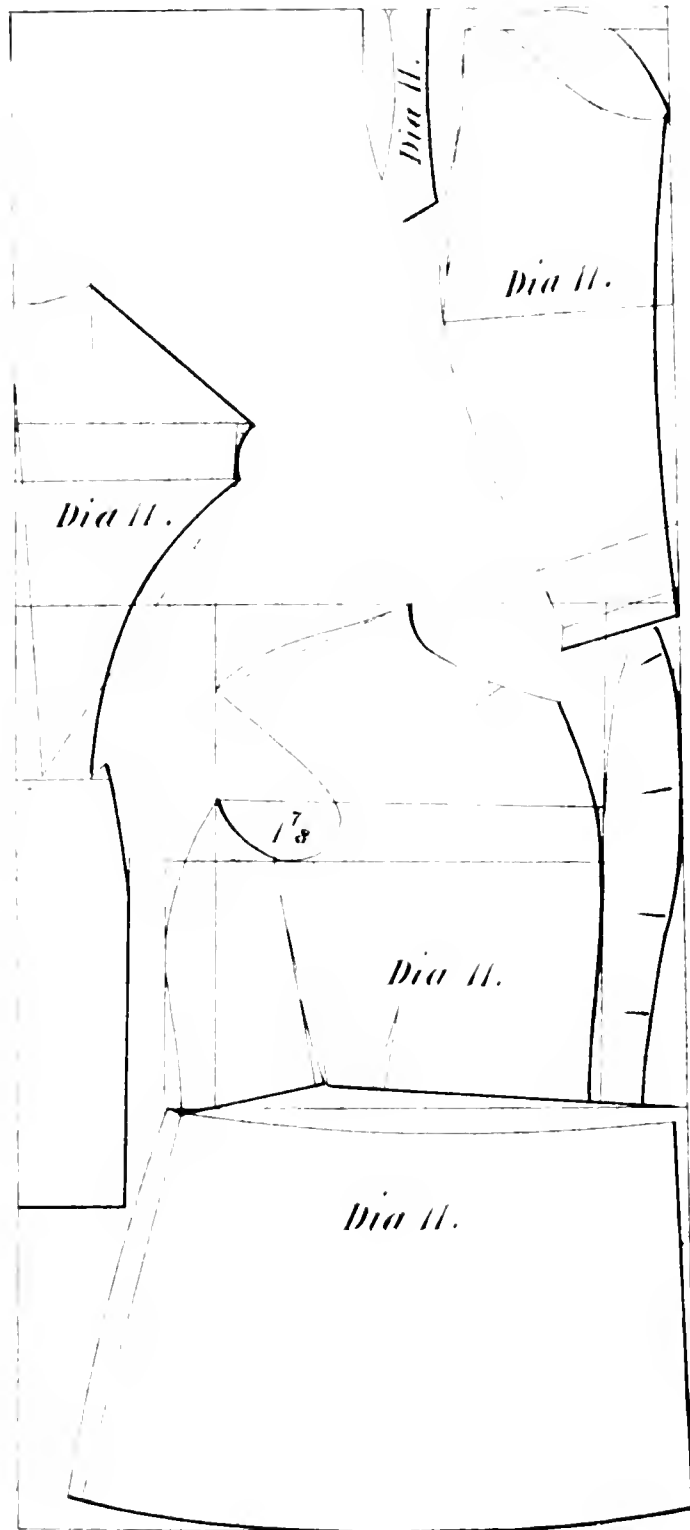


DIAGRAM N<sup>o</sup> II.  
MADE UP.

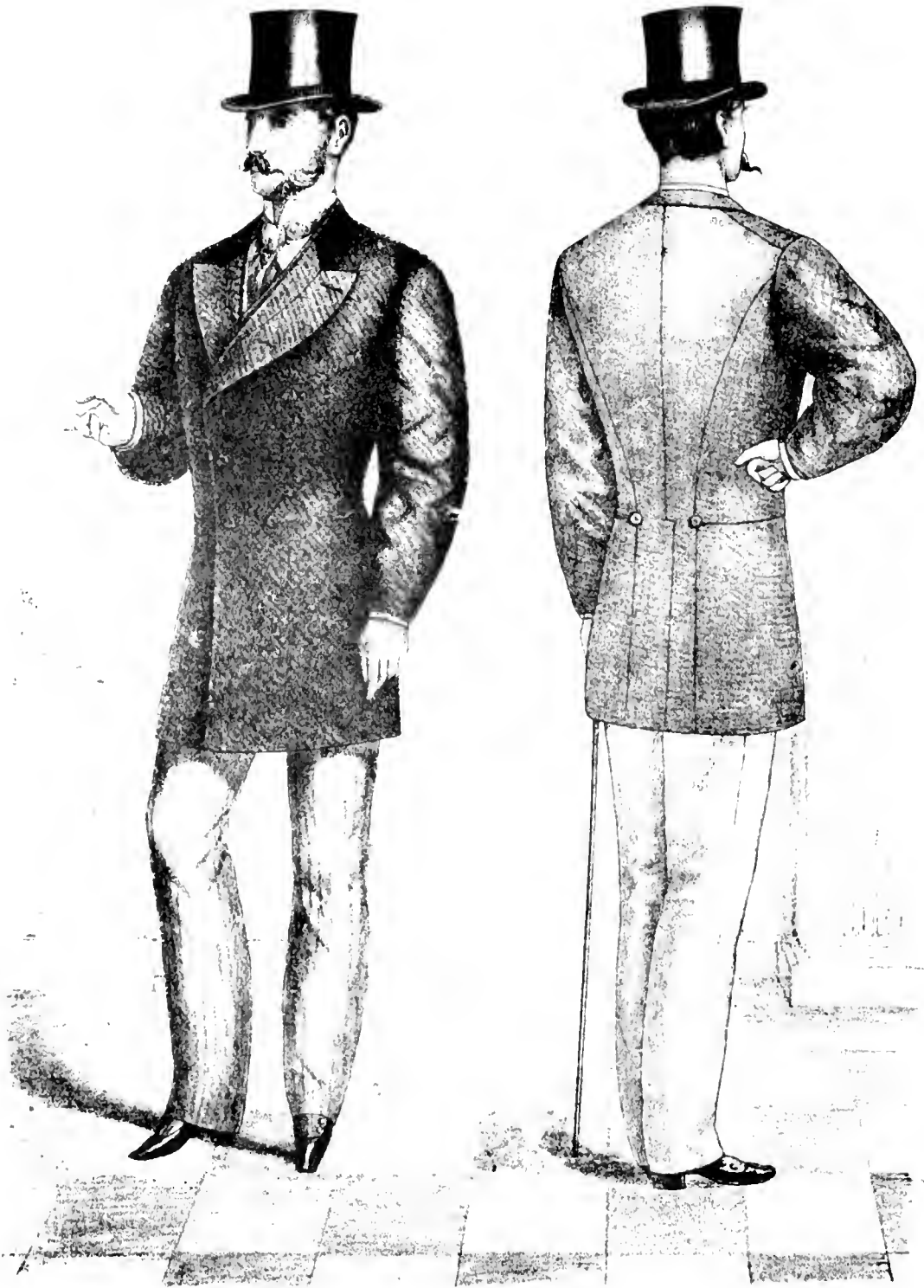
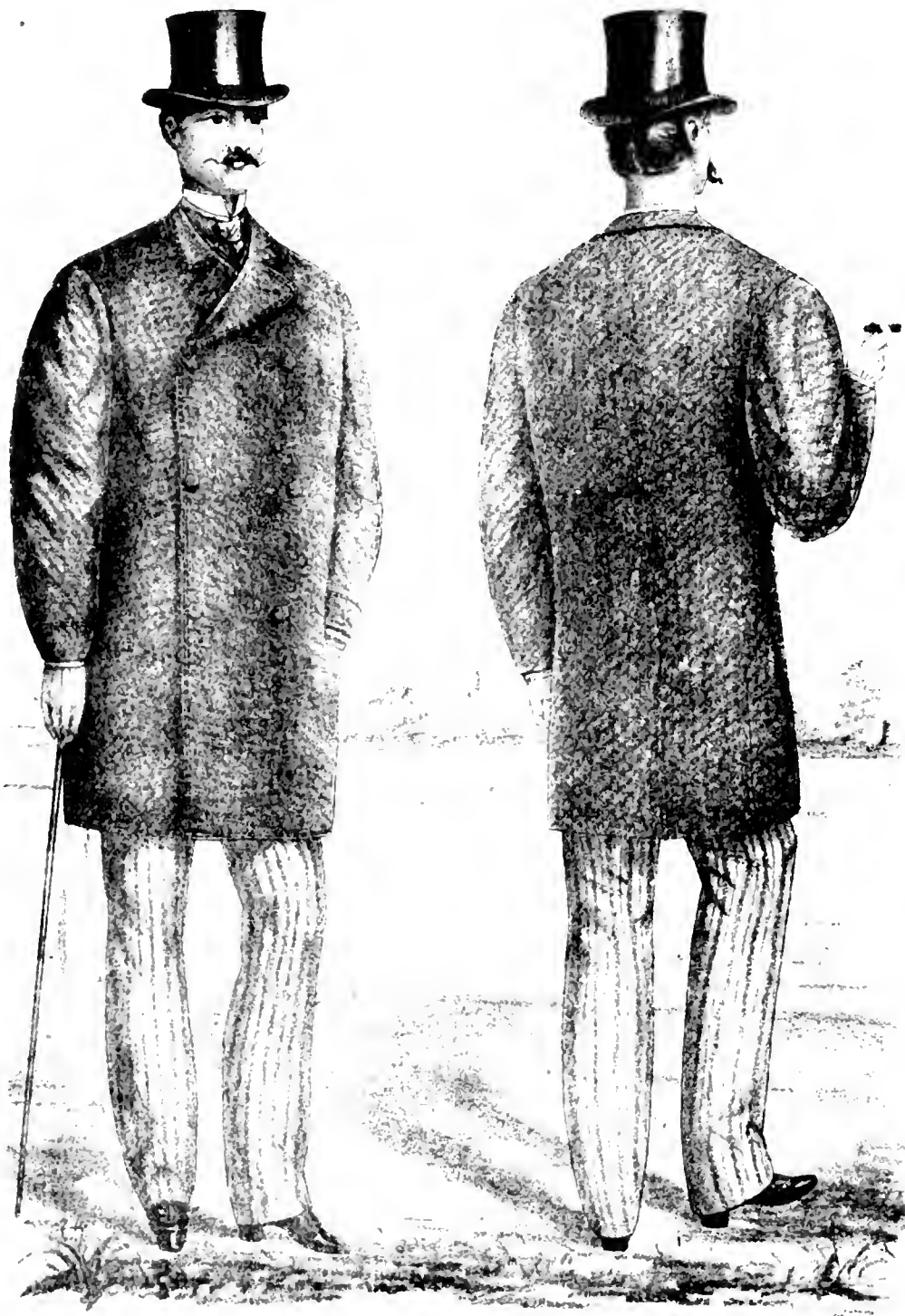
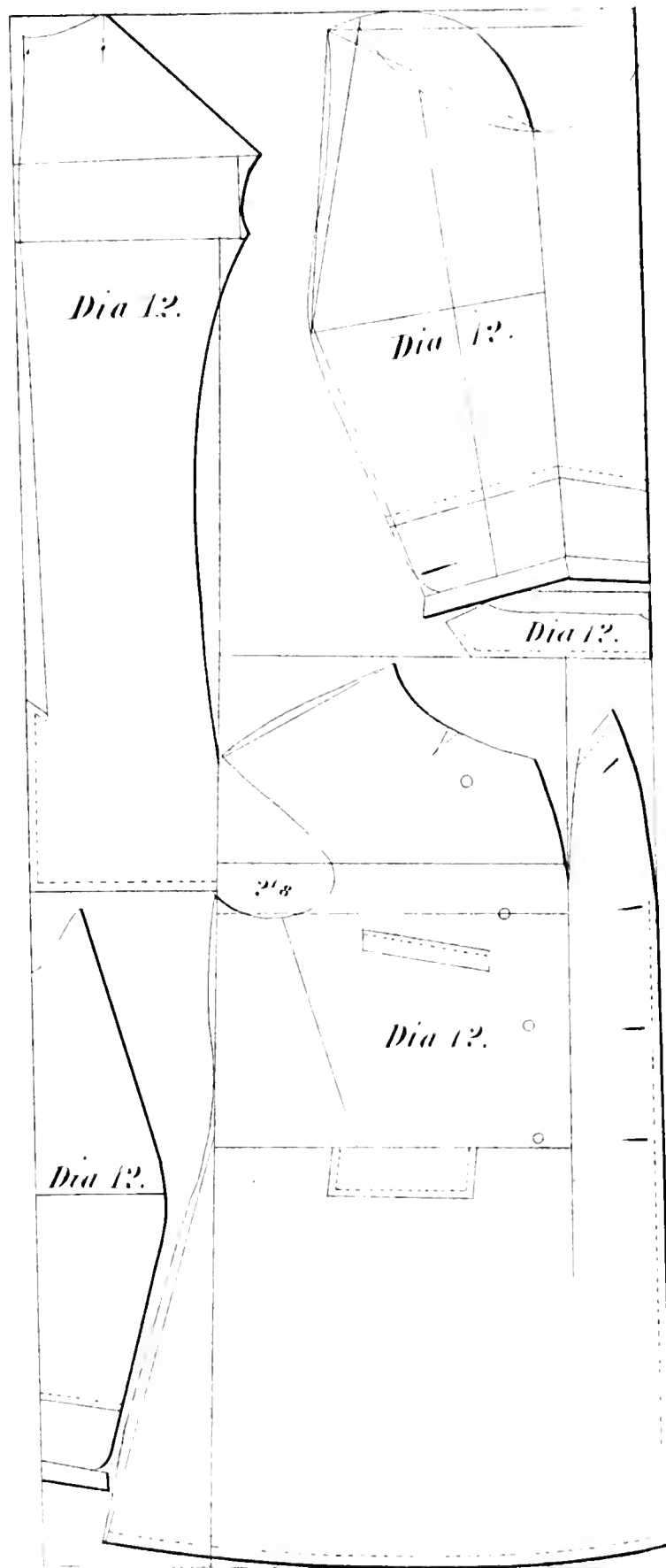


DIAGRAM N<sup>o</sup> 12.  
MADE UP.







## DIAGRAM No. 12

Represents a Double-breasted Sack Over-Coat, half tight, and a little inclined to fit the body. It is a winter over-coat, and is only made from heavy materials, such as beavers, pilots, chinchillys, whitneys, &c., &c. Such a coat will take two yards and a half of cloth of the usual width (fifty two to fifty-four inches). A coat of this kind ought to be lined with light tweed or a good quality fancy flannel. Sleeves lined with good quality linen to match the linings; strong jean pockets, which ought to be well stayed in over coats, as they are larger and heavier than those in under-coats. They require to be put firmly together in all parts of the coat, using good heavy canvas for all over coats made of heavy material. Such coats ought to be bound, if the cloth is not of a very good quality; if it is, then stitch the edges single or double, according to fashion. The Sack, whether for under or over-coats is the easiest coat made, as there is less shrinking, pressing and shaping on it. The fore scye is the only part that requires stretching—but all coats, whether small or large, ought to be stretched at this point. The shoulders of an over sack-coat should be one inch wider than an under coat for the same figure; therefore the broad requires to be well padded in order to maintain its shape as long as the coat will last. The facings and fore part linings should be put in rather tight, and well fastened to the side seam, down to the pocket tacks. This will keep the facings from coming forward, and keep the collar from rolling to all parts of the coat, as is often the case with garments that are improperly made. To some tailors this mode of putting in facings and linings may seem rather strange at first, but once tested, it will be sufficient to prove the assertions made here to be quite correct—not only correct, but the only true principle to build the inside of a coat that will keep its form from rolling outwards to all parts of the breast.

## DIAGRAM No. 13

Represents a Single-Breasted Fly-Sack Over-Coat. This Coat is more stylish and nobby than the Double-Breasted Sack Over-Coat, and is generally made from finer grades of goods ; two to two and a quarter yards of cloth will make a coat of this kind for an ordinary sized person. This coat ought to fit closer to the body, and spring out over the hips in a graceful manner, but not so much as to form wrinkles. The nicest lining for a coat of this kind would be good strong Italian cloth, quilted in a neat manner, as it will give the coat a good effect and appearance, especially when it is off. In Light Over-Coats of this kind there should not be any wadding used in them, when they are for Spring or Fall wear, plain linings and light canvas, stitched edges, single or double, with silk facings. A coat made in this manner looks very genteel upon a young person, but I would recommend every Cutter to impress upon their customers to have all their garments made according to the latest fashion ; it will be one of the best means to increase your business, as a Fashionable Tailor will always have trade when the old fogies will have none. One of the most important and essential things for a merchant tailor to do is to get all garments well made, and to accomplish this you must employ the best tailors that you can command. Let a coat be ever so well cut, there are ten chances to one that it is killed in the making, if it is made by a poor workman ; therefore, it is very important to every Merchant Tailor and Cutter to attend and inspect every garment at certain stages of its progress towards completion, and see for yourselves, in order that you may be a better judge of what you so highly recommend to your customers ; when I say highly, I say so because I never knew a man yet to run down whatever he is trying to dispose of, therefore, if you wish to succeed in any undertaking, recommend everything only in its true light.

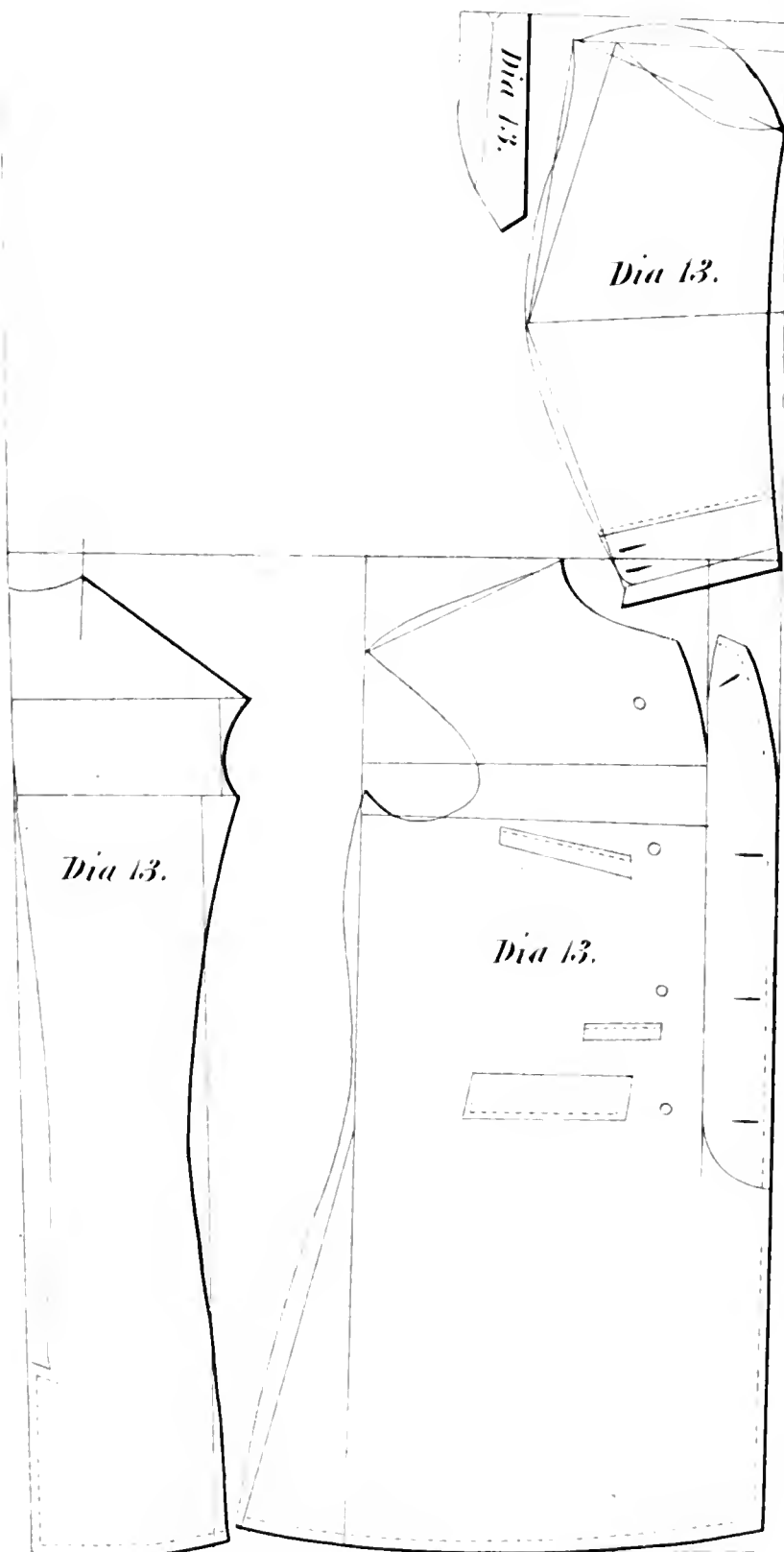


DIAGRAM No 13.  
MADE UP.

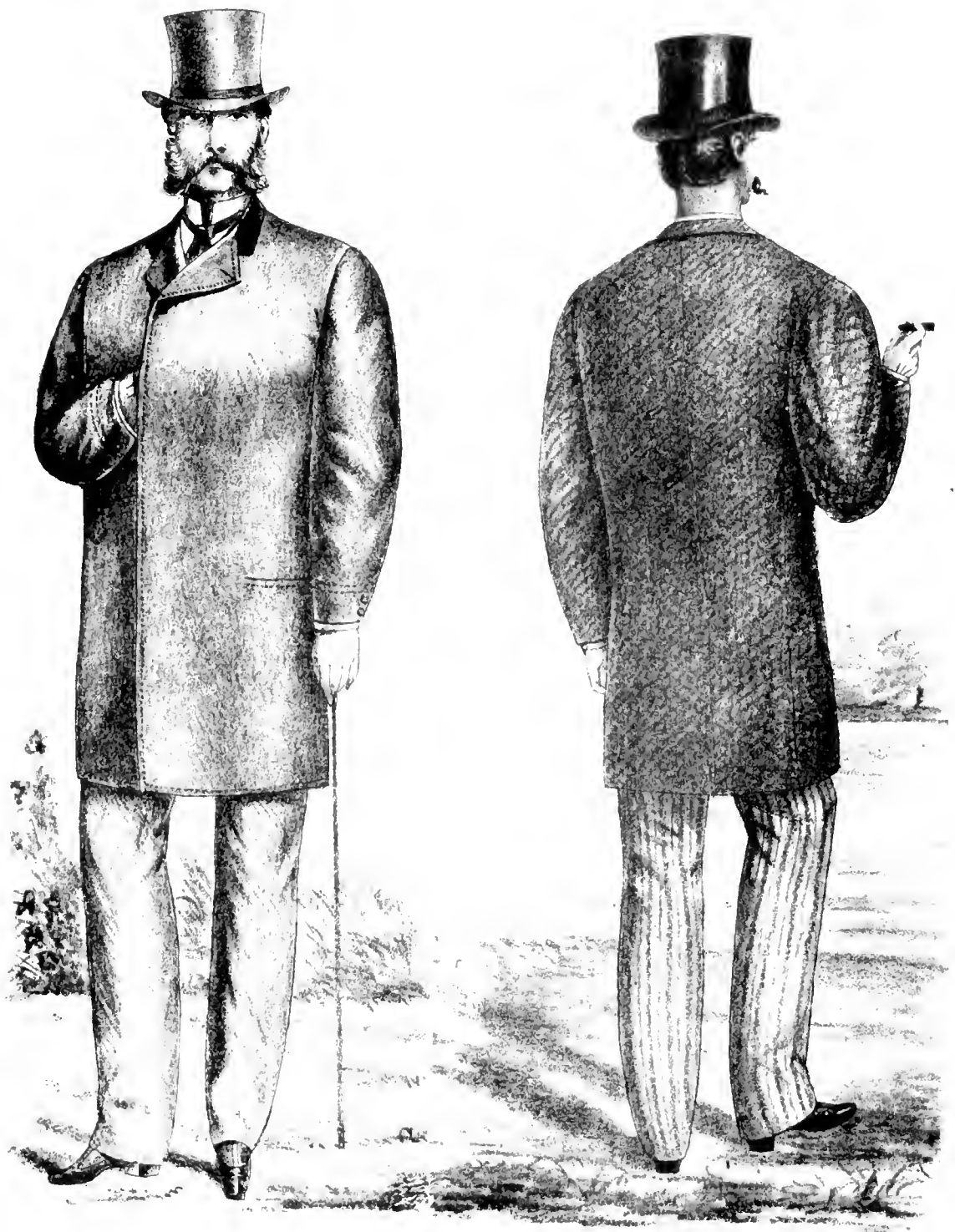
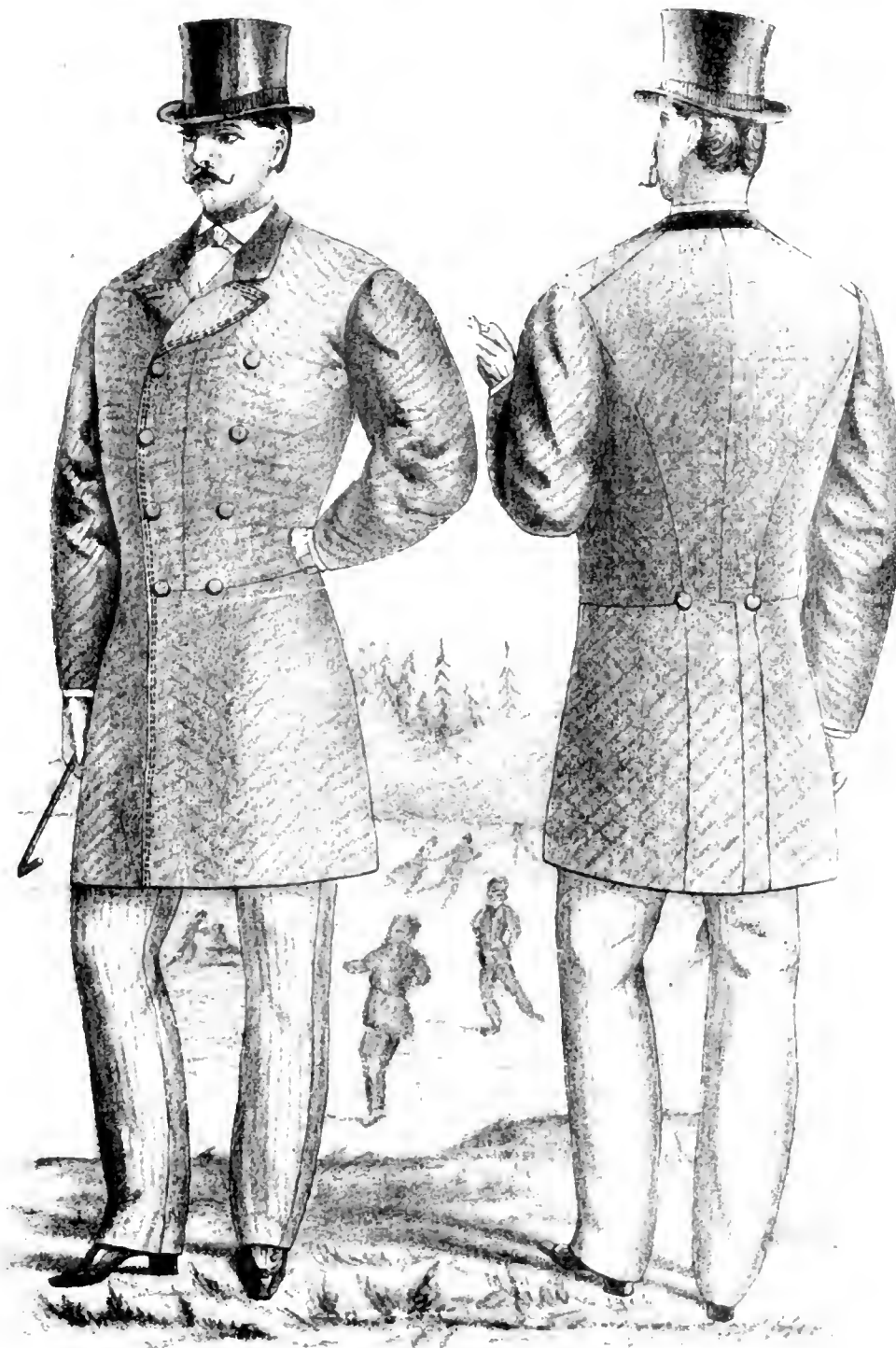
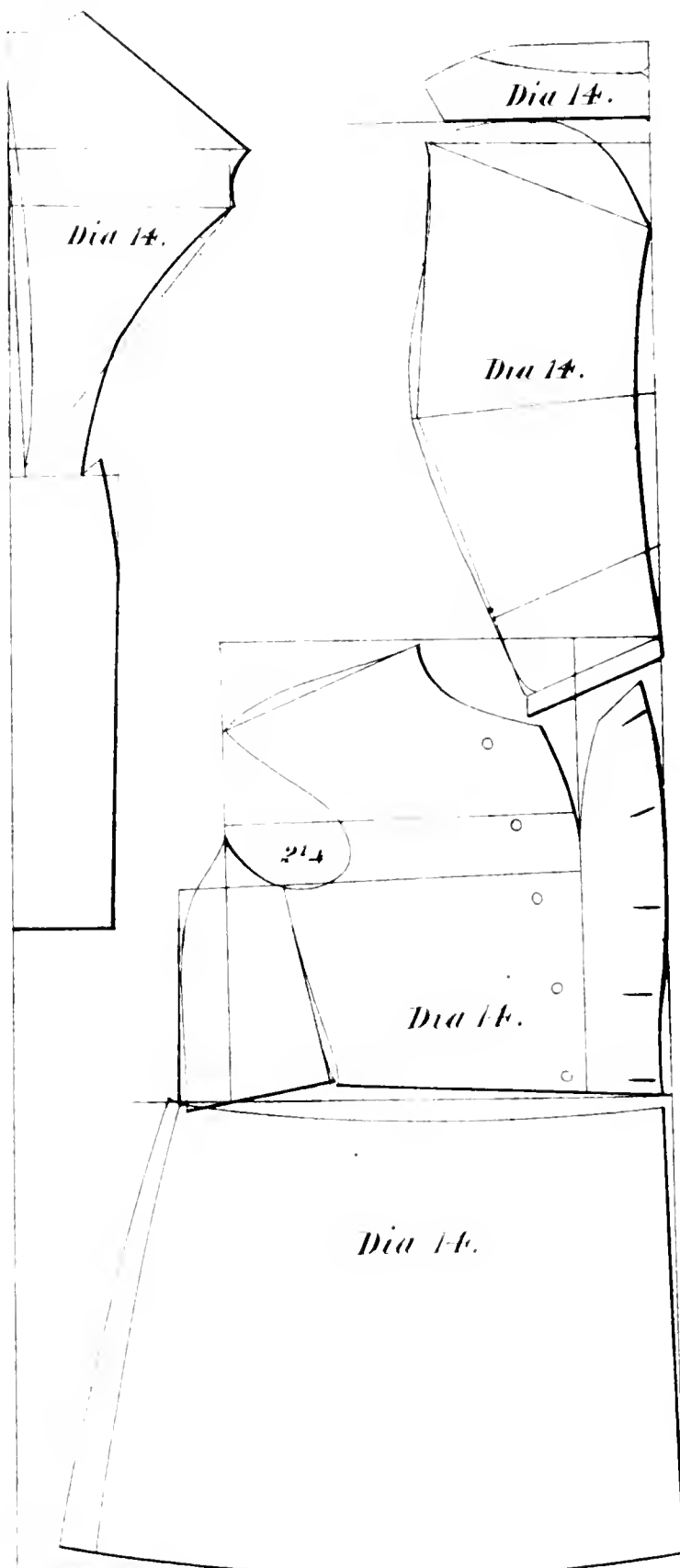


DIAGRAM N<sup>o</sup> 14  
MADE UP.





**DIAGRAM No. 14**

Represents a Double-Breasted Frock Over-Coat. This coat is a full dress Over-Coat ; it is more worn by the better class of customers, as it is a more expensive garment than any other kind of coat, if made from fine goods, such as fine dress beavers or heavy broad cloth. A coat of this kind should be lined with the best quality of Italian cloth, as it is more durable than silk serge in any over-coat, and looks equally as well, when it is of good quality, the body and skirts neatly quilted or plain, as the fancy of the customer may dictate ; use fine canvas and good padding through the breast and shoulders, build the shoulders as shown on Diagram 40, and you will have a good square shoulder, which is very essential in such a coat. This coat is made with and without binding, bluff and stitched edges, but make according to the prevailing fashion would be my advice. This kind of a coat will take from two and a quarter to two and a half yards of cloth for an ordinary sized man. The Frock Over-Coat is cut on the same principle as the Under Frock Coat, therefore, every Cutter that is interested in the welfare of his profession ought to endeavour to sustain the integrity of this magnificent piece of architectural science on the human body ; in reality a Frock Coat that is well cut and made, whether under or over, is one of the most skilful and magnificent pieces of workmanship that the hands of man can execute in tailoring, or anything else, if made perfect.

**DIAGRAM No. 15**

Represents a Single Breasted Roll Collar Vest with four buttons on. This vest is 25 inches long, the collar rolls down 15 inches on the breast; this style of vest is made from all sorts of materials, and will only take 24 inches of cloth three quarters wide to cut the fore part from, and that is for a 40 inch breast, the collar of this vest can be cut to roll high or low to any desired style or fashion. The back can be drafted from the fore parts as shown on the diagram, or it can be drafted separately according to circumstances or dictation, but in all cases the back shoulder point must be from one to two inches shorter than the fore part shoulder point. The back is cut in every case two inches wider than half and breast measure, while the fore part is cut exactly to half the breast measure; therefore the fore part is cut one half the measure and two inches more than the half added to the back which will not be much when made up. This diagram is drafted by the system showing the manner that the vest is drafted from the cloth using only three points to accomplish it, namely, S. P. for shoulder point, B. S. for bottom of seye, and S for shoulder width. By these three points a vest can be drafted for size or figure, in any shape or style.

**DIAGRAM No. 16**

Represents a Low Single Breasted Vest without a collar and only with three buttons on. This vest is 26 inches long, 40 inches breast, and opens down upon the breast to 19 inches. The fore parts of the vest will take 23 inches of cloth, three quarters wide, and can be made to button up close to the neck or button down to one button if desired. This vest can be made with a small collar, when buttoned close up: in this style it is called the Prussian Collar Vest, or a Military Vest. This vest is made from all kinds of material, and in the summer season it is very much in use on account of its lightness and being made from light material such as linens, Marseilles, &c. The draft shows the manner that the vest is drafted by the system, as in the preceding diagram, the same rule applies to all the vests drafted by this system. Simple it may appear at first, but, after it is tested, it will be found to contain all the merit that is claimed for it.

**DIAGRAM No. 17**

Represents a Double Breasted Lapel Vest with four buttons on a side, and opens down to 17 inches on the breast. This vest is 26 inches long, 40 inches breast, and will take from 27 to 29 inches cloth three quarters of a yard wide. The lapels can be left on or cut off, according to taste—the vest will look well in either case. This style of a vest is more suitable for the winter season, and is very comfortable in cold weather when made to button high up, although it is made from light material in the summer season, and button down to two buttons on a side. In drafting this vest commence to draft in the same manner as in the single breast, then adding the lapels to the breast to the desired size or fashion, which will be found to be quite correct and easily understood by any person possessed with the ordinary abilities of the individuals. Refer to the draft for further instructions, which will be better understood at first by most persons not much accustomed to drafting, but are continually using patterns to produce drafts.

**DIAGRAM No. 18**

Represents a Double Breasted Roll Collar Vest with three buttons on a side and opens down to 19 inches on the breast. This vest is 26 inches long, 40 inches breast, and will take 26 inches of cloth three quarters of a yard wide to draft a vest of this kind from. This style of vest is more suited for the summer season or a dress vest, as it will expose the bosom of a nice and well dressed shirt, which is so very essential to the appearance and completion of a full dress suit. The vests are made sometimes to button high up, and, in fact, in all shapes, although its originator never intended the vest for any thing but for a full dress. Commence to draft in the same manner as the single breasted vest, and adding the difference as in the double breasted lapel vest, in this manner a correct draft can be produced every time with the greatest of ease and satisfaction to all persons concerned. Refer to the draft for further instructions which will be found to be very instructive and easily understood, which is better than all the written instructions that could be written until Doom's-day in this work or any other work. Therefore study the drafts and follow the fashion and the word fail you shall never know.

**DIAGRAM No. 19**

Represents a Single Breasted Roll Collar Vest. This vest buttons high up, rather close to the neck, and may be termed a winter vest; it is 25 inches long, 39 inches breast, and will only take 23 inches of cloth three quarters of a yard wide, to draft this style from.

All the foregoing diagrams show the principle and manner in which all the different styles of vests are produced by the system. The system will draft all parts of the vest separately if required. In drafting a vest, whatever the breast measure may be, give the fore part half that measure, and, to the back part, add two inches more for seams, &c., which will not be much when made up. For instance, suppose you are going to draft a vest for a person 40 inches breast 25 inches long, commence by forming a square 22 inches long, 10 inches wide, then begin to gauge this square in the following manner: the side seam and seye next to you, then take the gauge and mark points S. P. and B. S. for shoulder points, and bottom of seye, then the width to shoulder seam and the length of collar roll, then draft in all the points of the fore part; then commence the back in the same manner as the fore part, by forming a square, adding two inches more to the width, and the difference for the rise of the back shoulder which will be from 2 to 3 inches as the case may be, then measure the length of the fore part side seam and fore seye, then apply the same measure to the square just made, measuring from the bottom to the bottom of seye, and on to  $1\frac{1}{2}$  to 2 inches less than the shoulder points of the fore part, mark these two points and square across from side to side and measure the width of the block and draw a line from the shoulder points to the bottom of seye line, then draft in all the points as shown on the diagrams. The collar will be fitted to the gorge in the same manner as in the coats, and shape to style or fashion according to taste. Vests drafted by this system will never fail in producing a good fit—if adhered to, the rule laid down in this work will be a never failing one.



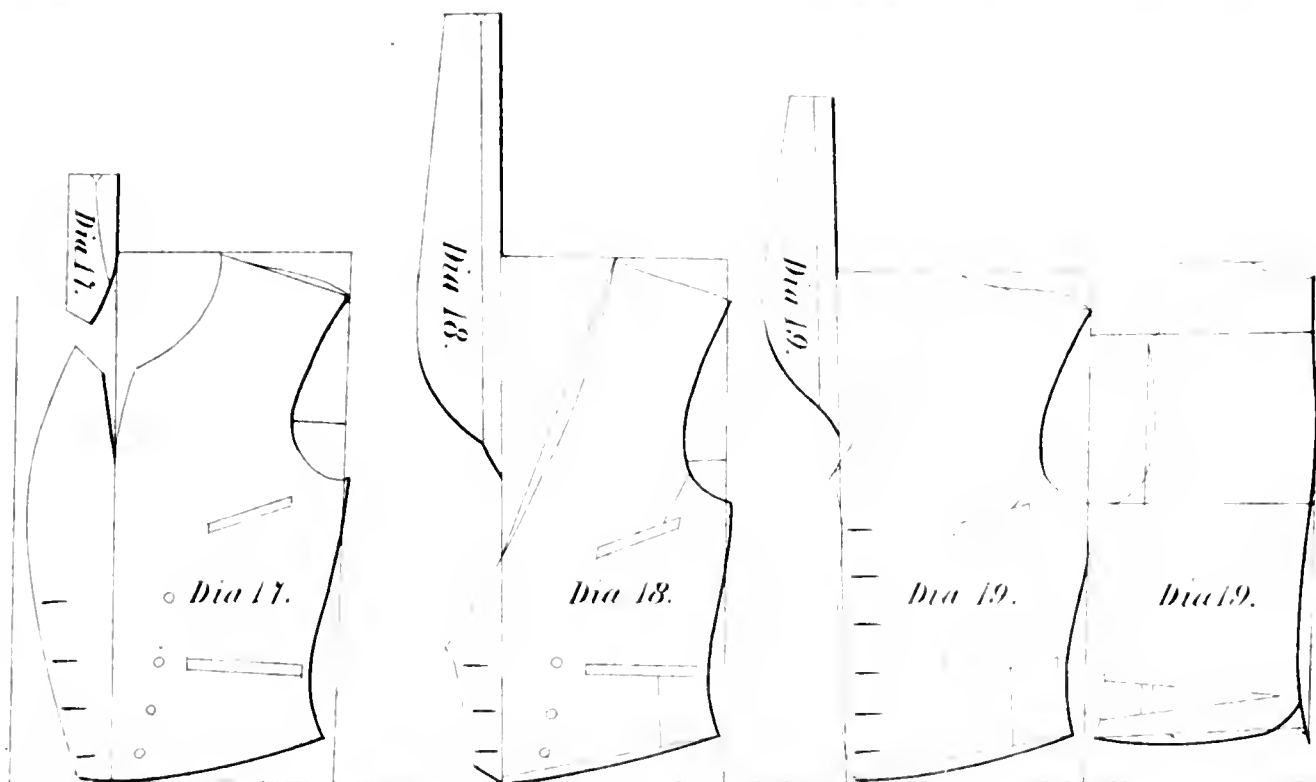
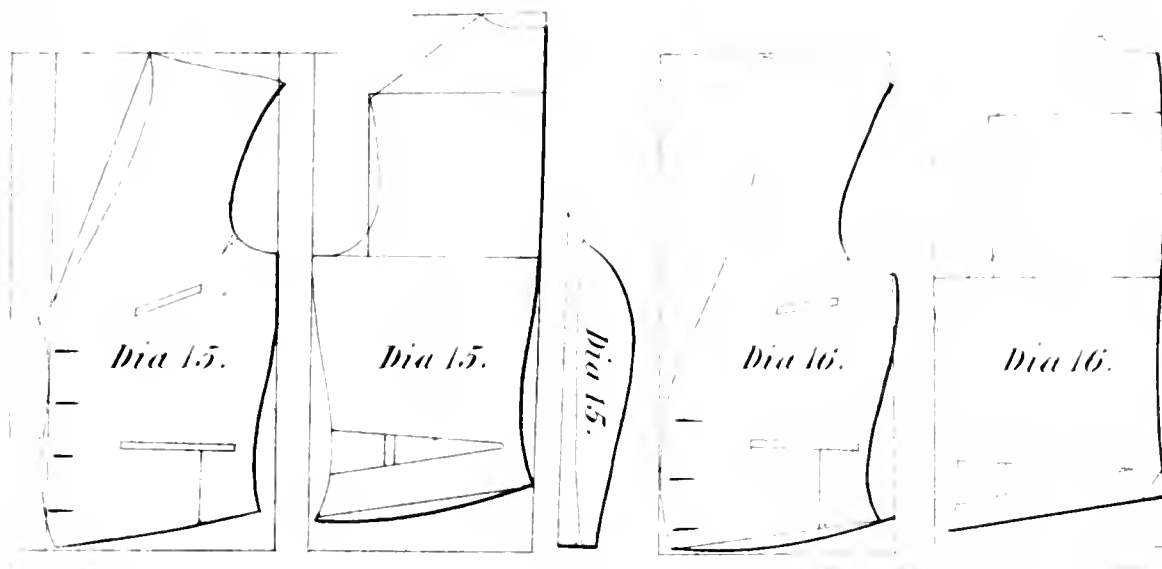
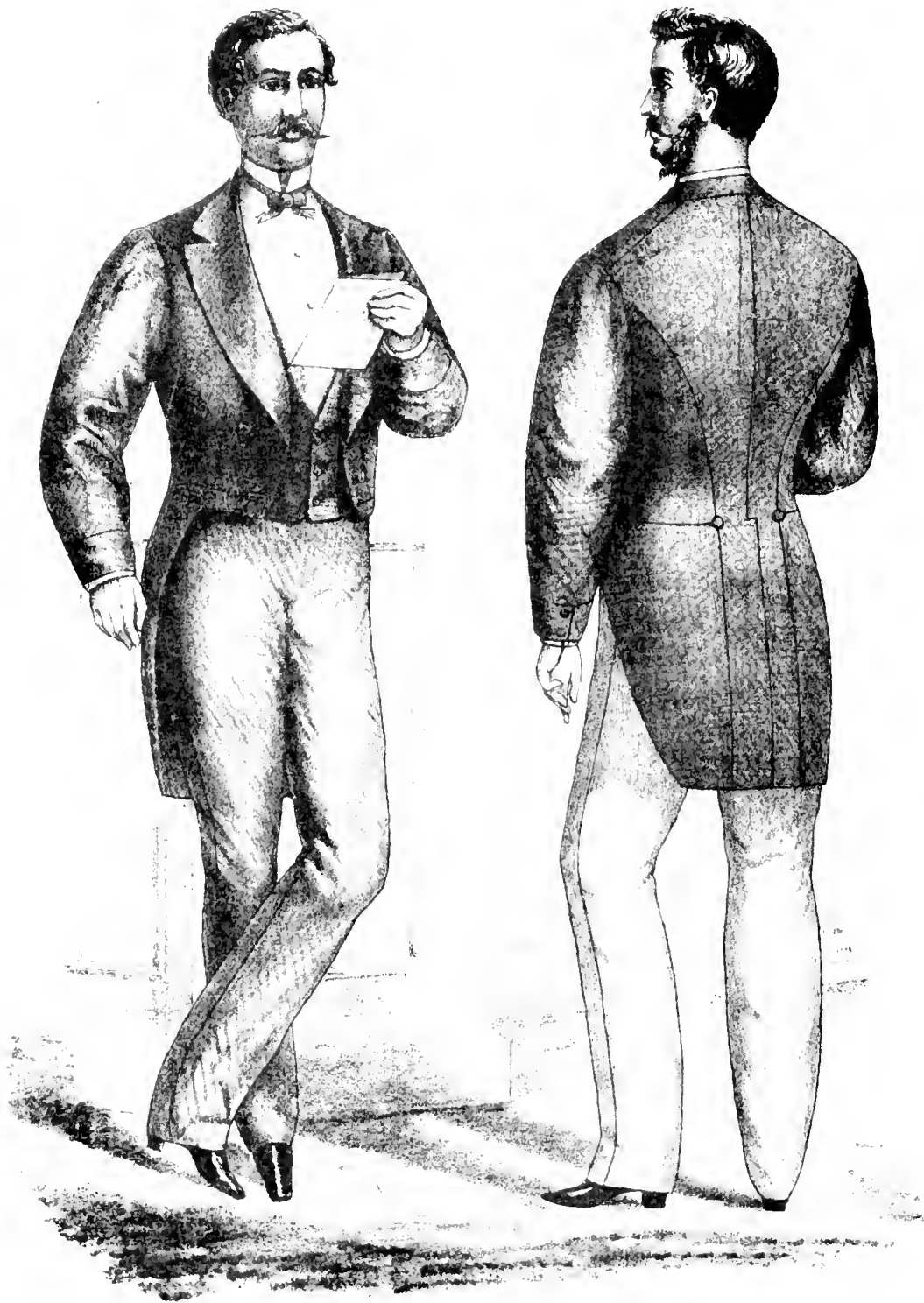
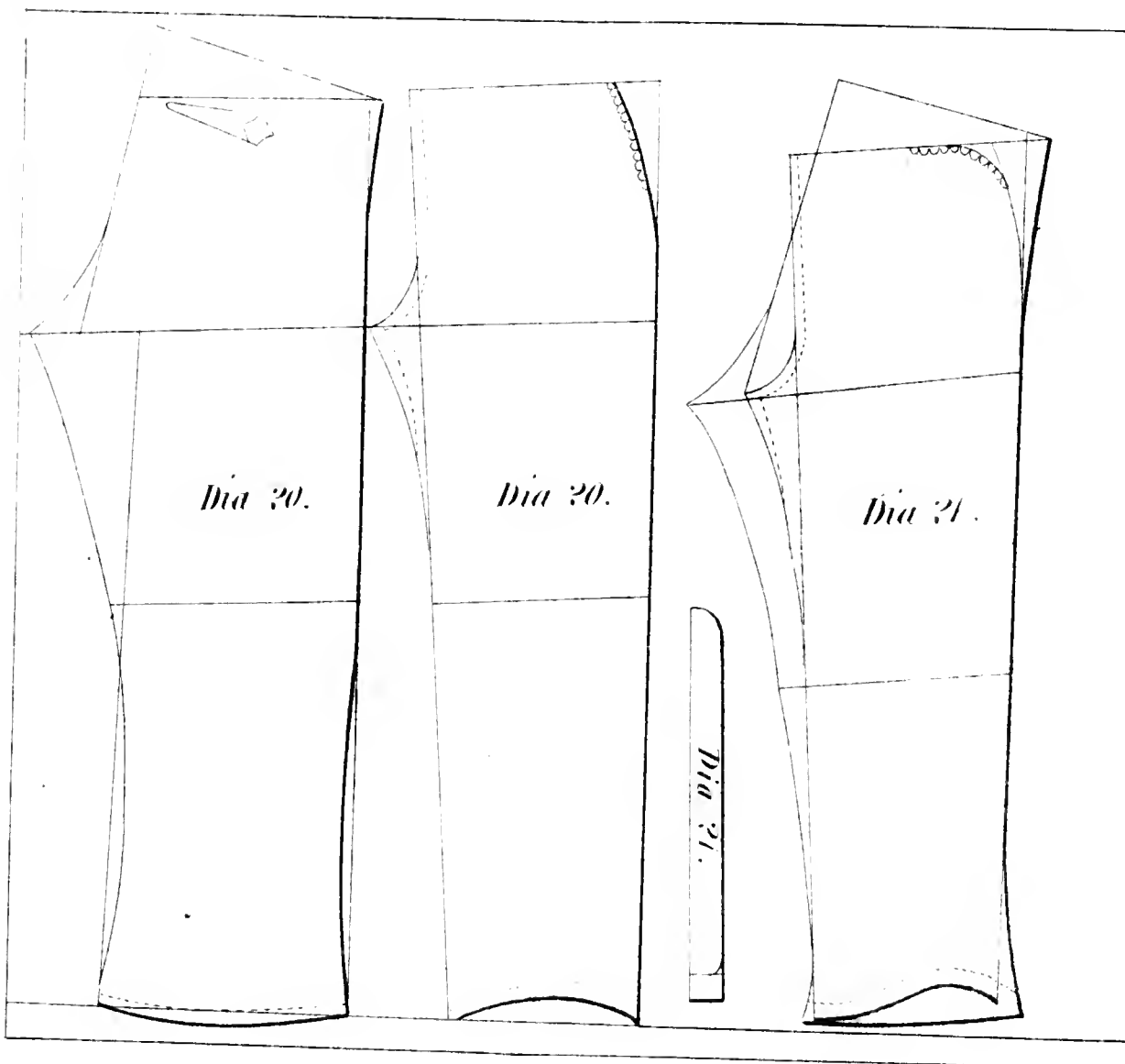


DIAGRAM N<sup>o</sup> II.  
MADE UP.





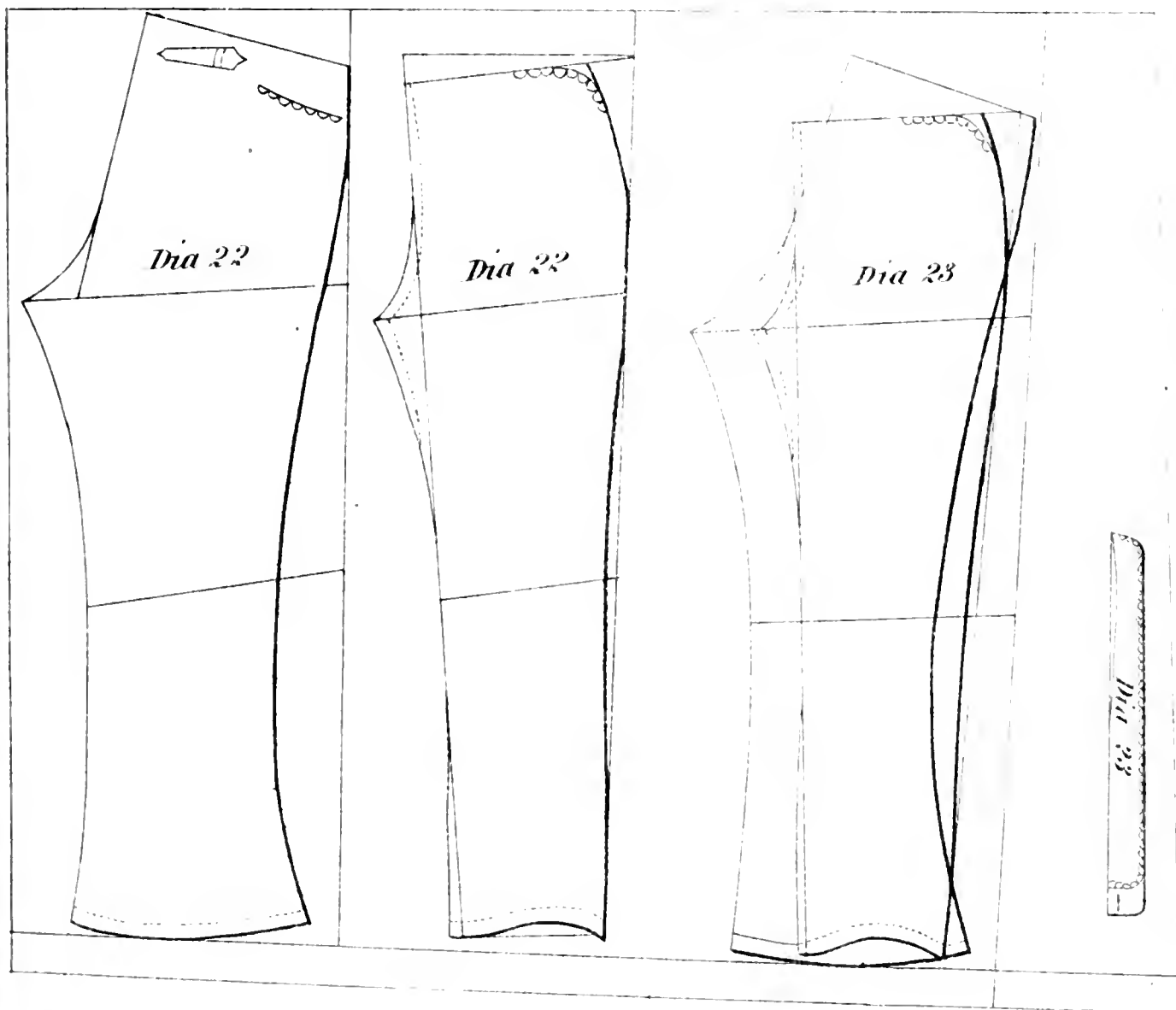


**DIAGRAMS Nos. 20 & 21**

Represent an ordinary pair of Plain Pantaloons, drafted in two parts, as shown on Diagram No. 20. This diagram shows the fore and back parts, drafted separately by the system. Diagram No. 21, shows the manner of drafting both parts together. Both of these diagrams are the same, and show that pantaloons can be drafted by this system, separately or together, as your mind may dictate. These are the plainest pants made, and are only worn by elderly gentlemen, as a rule. This diagram is drafted from three points, and a balance line on the fore part ; first, the rise of body, then the width of waist, the balance line, and the width fork, drafted into style, then place the fore part on the balance of the cloth that you have just cut the fore parts from, and draft, as shown on diagram No. 21, which will be about two inches wider than the fore parts in the legs ; at the fork and waist, take the sizes from the gauges.

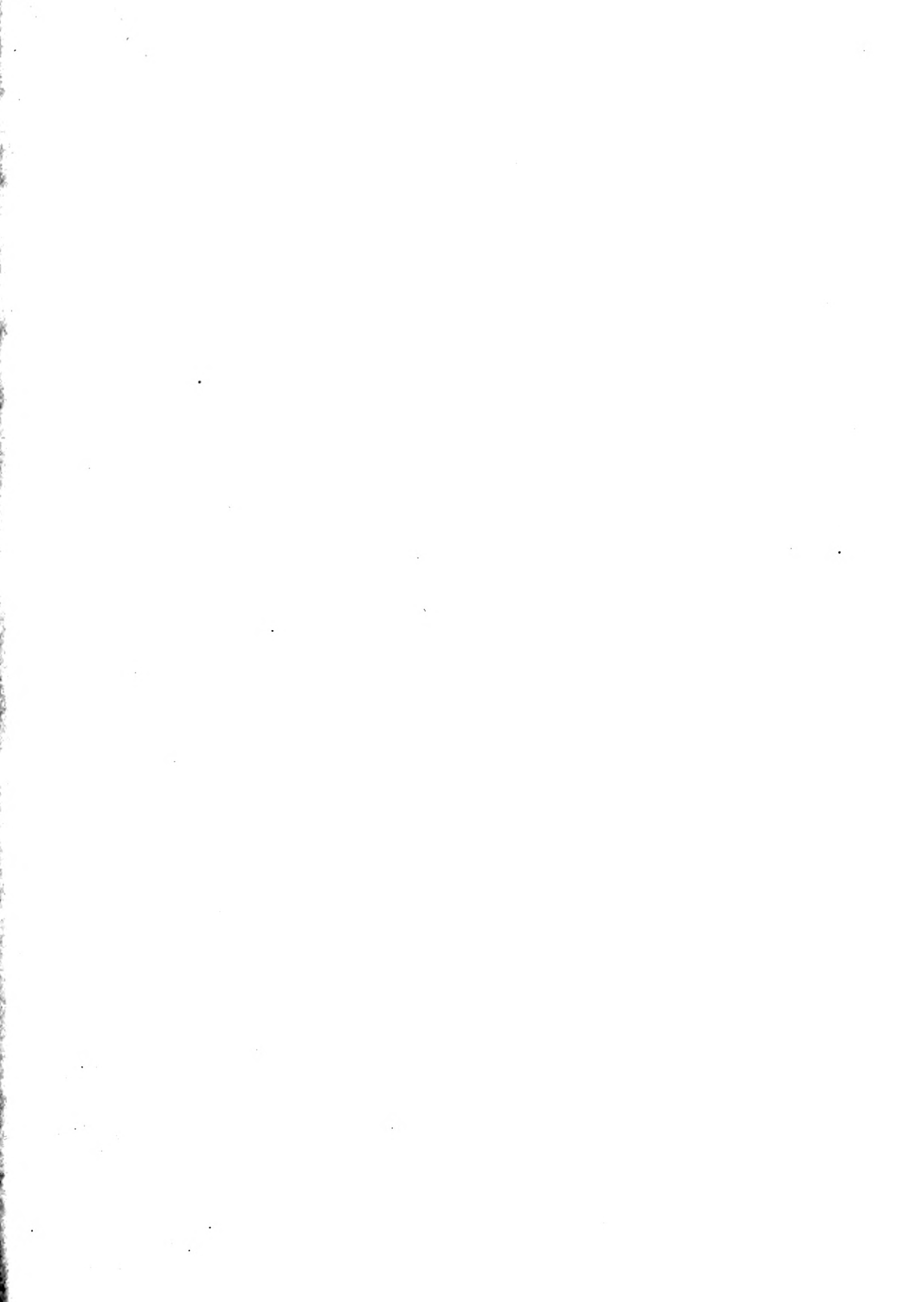
**DIAGRAMS Nos. 22 & 23**

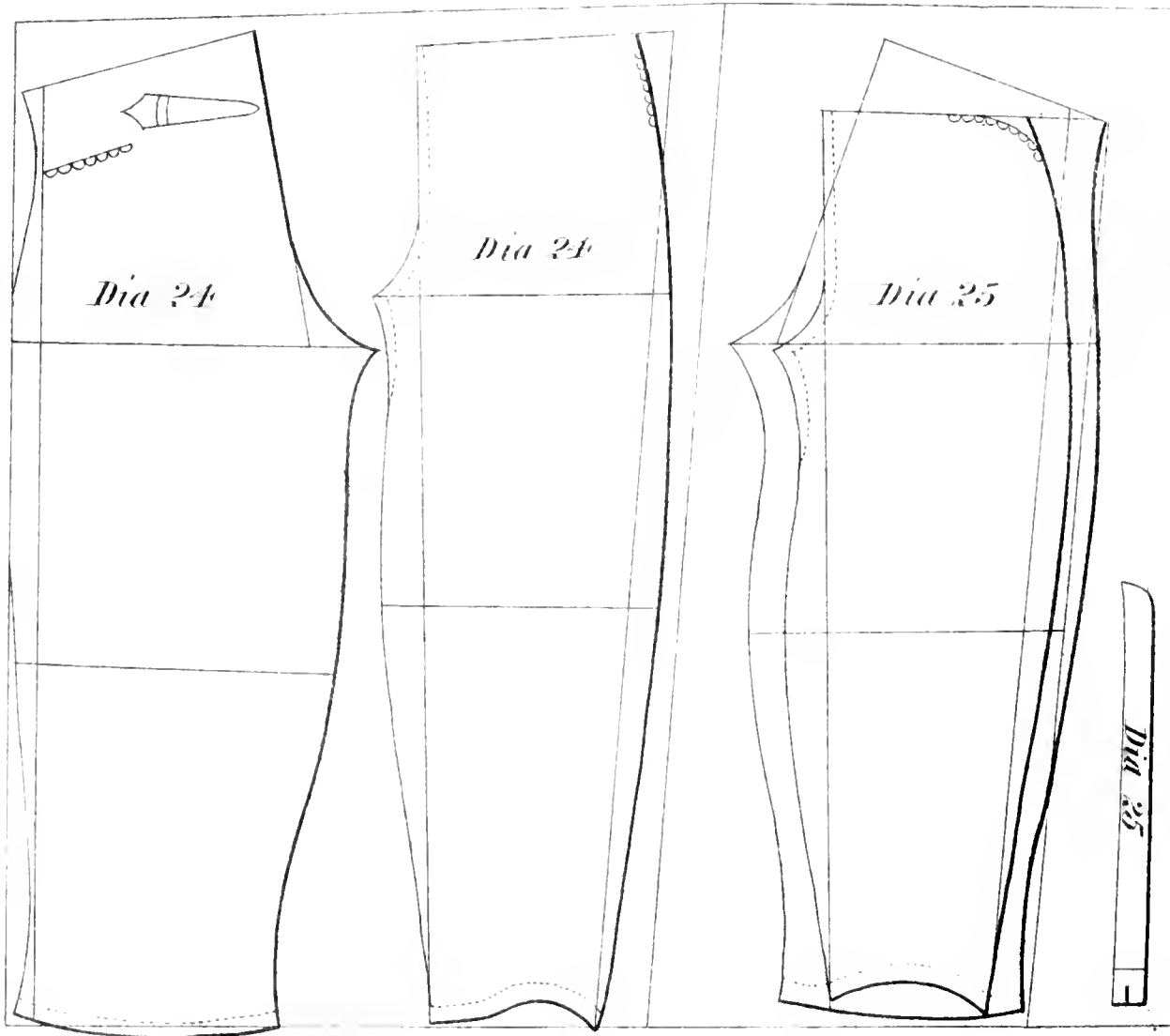
Represent Tight-fitting Pantaloons, drafted in separate parts, showing the manner that it is done ; in diagram No. 23 are the same Pants, drafted together, showing the manner that they are drafted in both ways. This style of Pants is cut from one to two inches larger than the leg of the customer, and sometimes a little sprung at the bottom, and they are designated as tight-fitting Pants. The fore parts and back are drafted as in the former diagram, only the difference in style, add to the size of fork in the back parts half an inch, and two inches at the waist, which will not be too much when made up ; when the fore parts are placed on the back parts, first shape the outside seam of the back parts to the desired style, then draw all the cross lines and the back body seam line, then measure the width at all the points, commencing at the waist, the hip, the fork, the thighs, the knee, and the bottom, then draft in all the points, and cut.









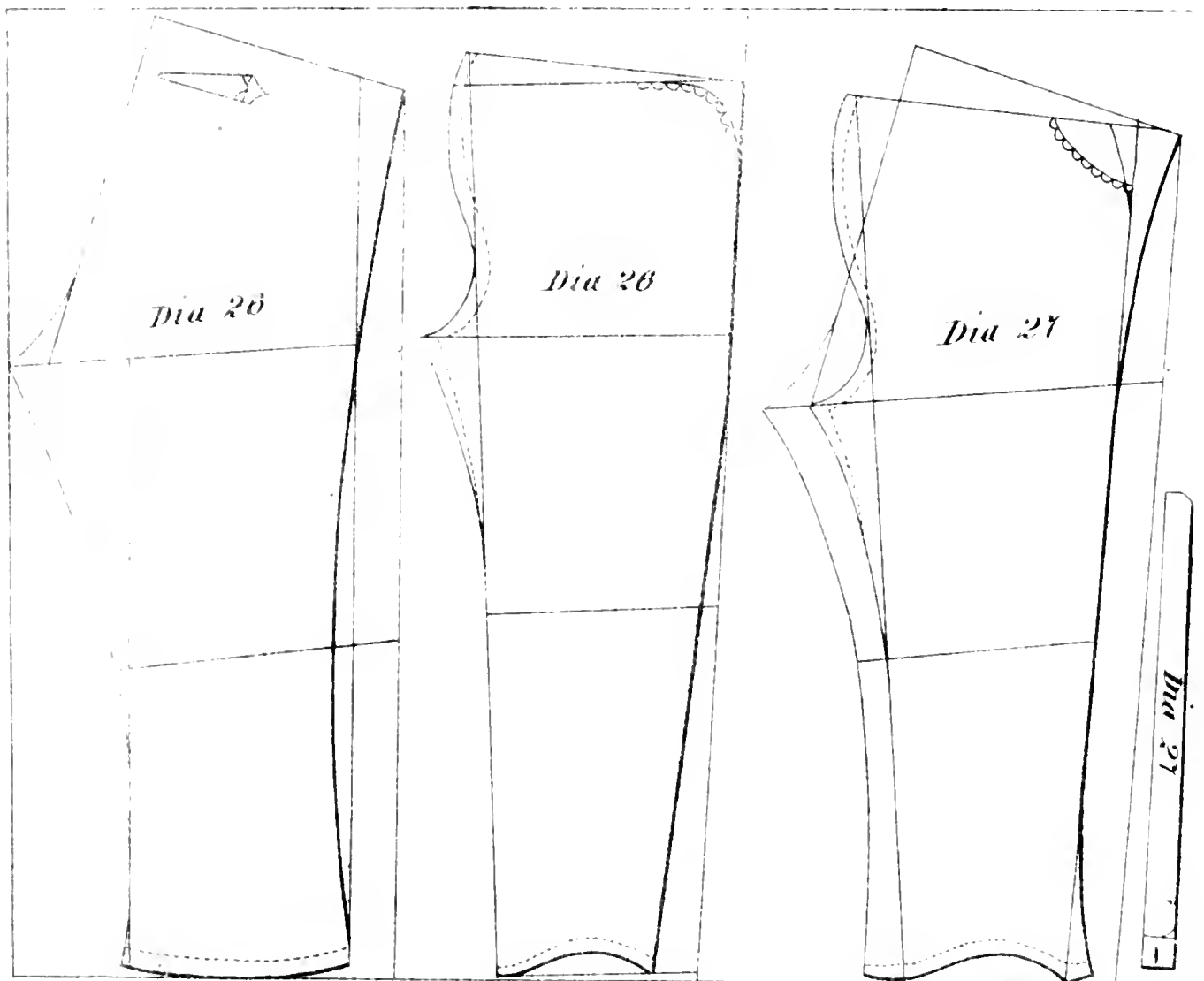


**DIAGRAMS Nos. 24 & 25**

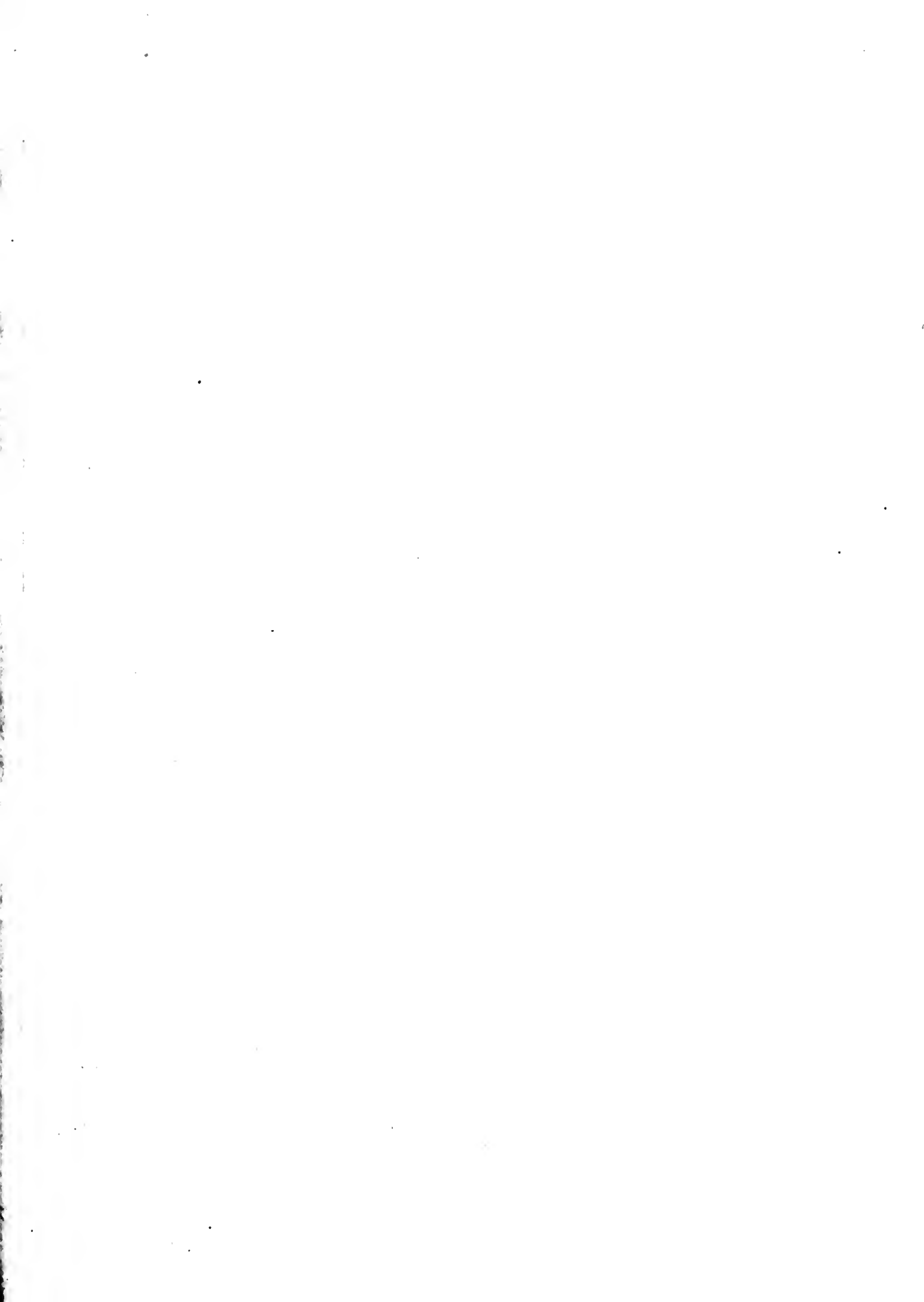
Represent a pair of Peg-top Pantaloon, showing the manner that they can be drafted in two styles ; diagram No. 24 shows the pants in two separate drafts, fore part and back ; diagram No. 25 shows the same pants drafted together in the usual manner. Peg-top Pants are the largest made, and are usually from 24 to 28 inches at knee, and at the bottom usual size 17 to 18 inches. This style of Pants ought to fit round the body as close as a medium size pair of Pants, although I have seen some cutters cut them big enough to go twice round the body, but it's all wrong with them. This diagram is drafted in the same manner as the latter diagram, only the difference in style, as shown by the diagram, dispenses with the hip measure ; but in all cases refer to the diagrams if you are not proficient in the art or profession.

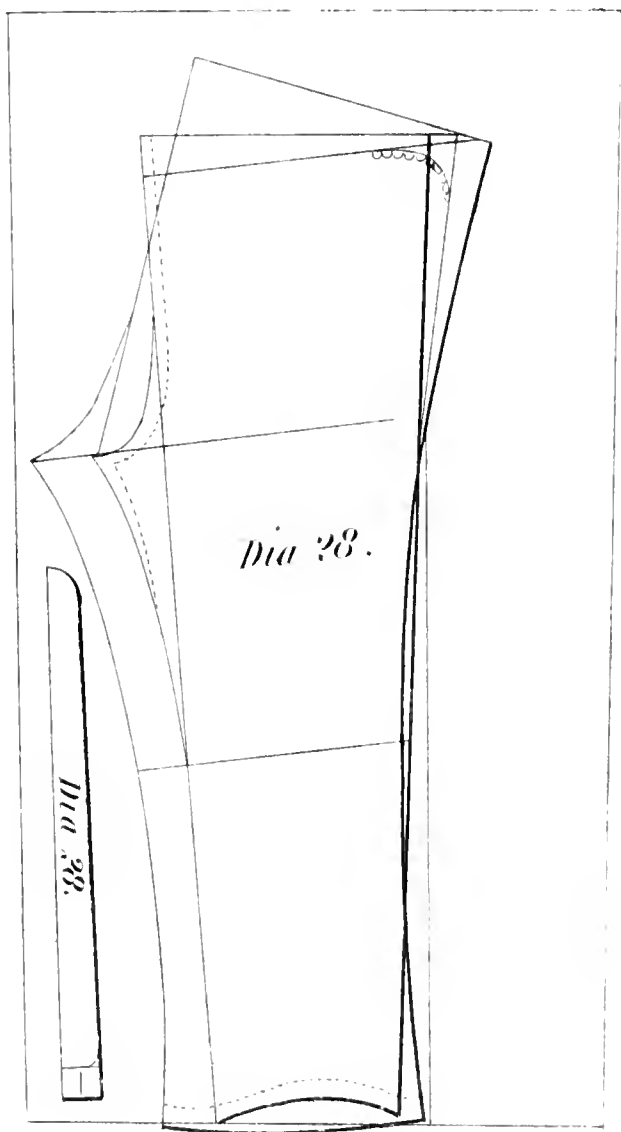
**DIAGRAMS Nos. 26 & 27**

Represent what I call the antediluvian style of drafting Pants for a corpulent person. This diagram shows the fore part and back, drafted separately, in a manner that any one, having the least idea of cutting, cannot fail to perceive the difference between the corpulent and incorpulent, although I have met with a great many cutters that did not know how to begin to cut pants of this kind. Diagram No. 27 shows the same pants, drafted together in the usual manner of drafting pants; but I have adopted in this work two methods of drafting pants, namely, separately and together, which will not fail to be beneficial to the new beginner, in showing both parts separately, giving a better idea of the manner that all the lines, points, and curves are produced, in which it cannot be so distinctly observed, when drafted together.









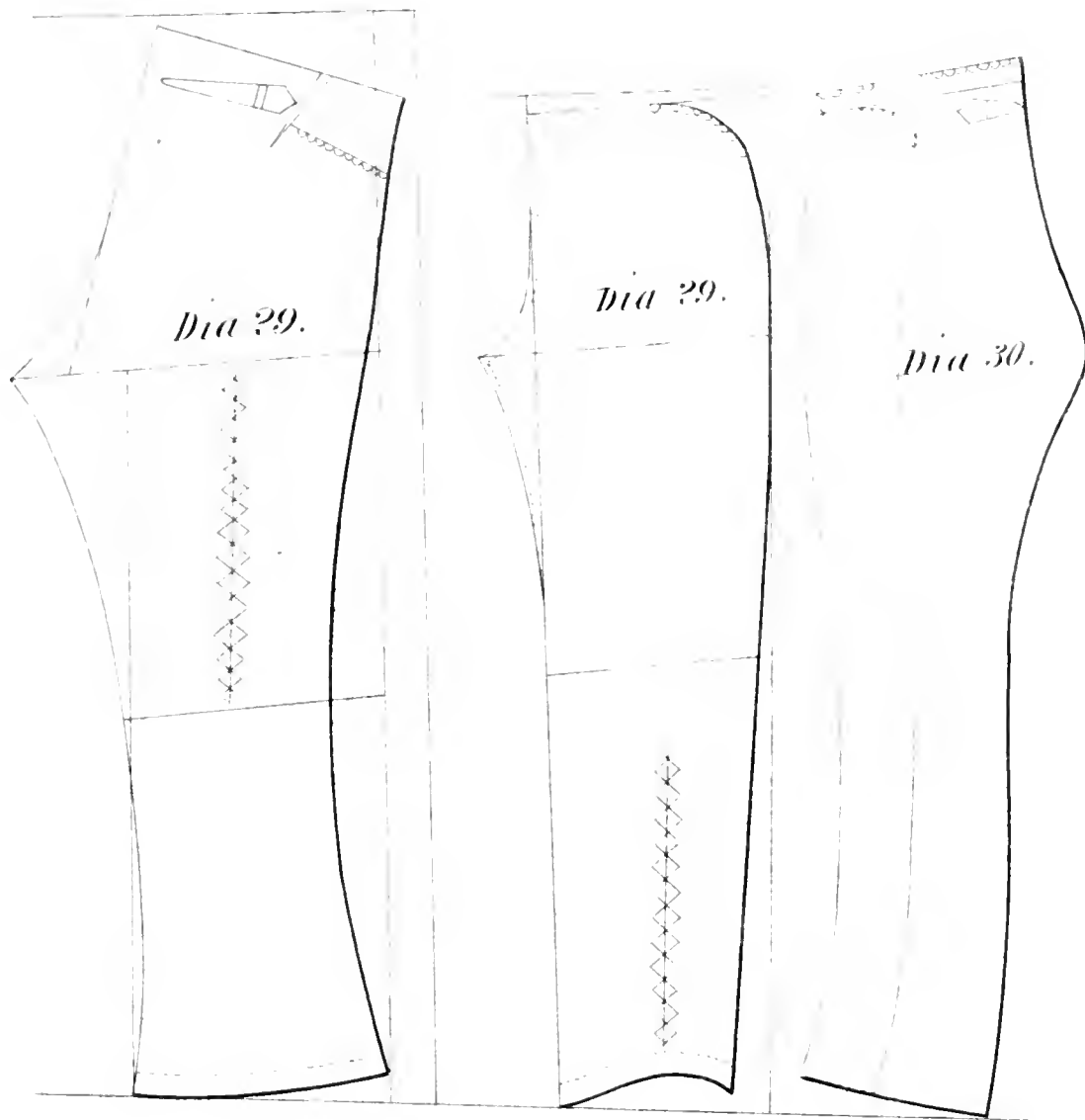


**DIAGRAM No. 28**

Represents the modern style of drafting corpulent Pantaloon. This diagram only shows the pants drafted together, in the manner that I have been in the habit of cutting such pants for a number of years with the greatest success, and are much neater-fitting pants in every respect than those cut by the old style. This style of drafting is entirely foreign to the profession, and is only known to myself, therefore it will be one of the most important things in this work for any cutter to know this method of drafting pants of this description. It does away with the surplus cloth usually found in pants of this kind when sitting. A corpulent person can be fitted by this method of drafting as easily as an ordinary person.

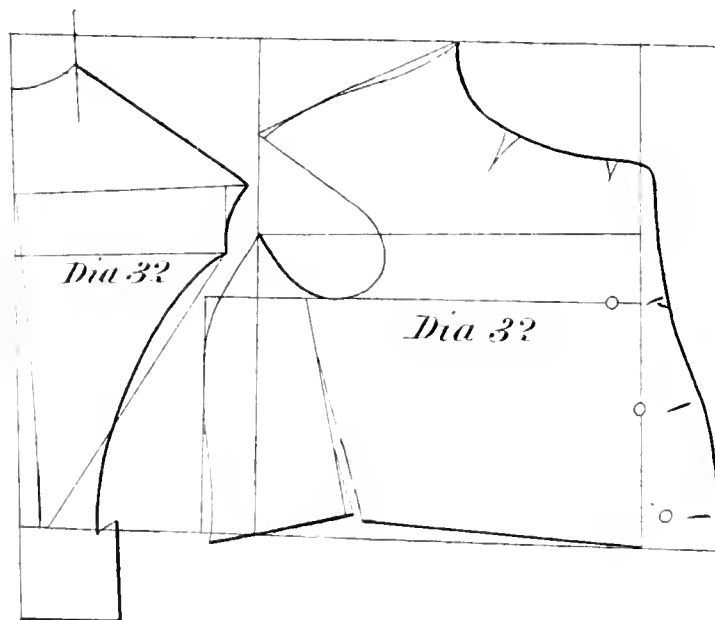
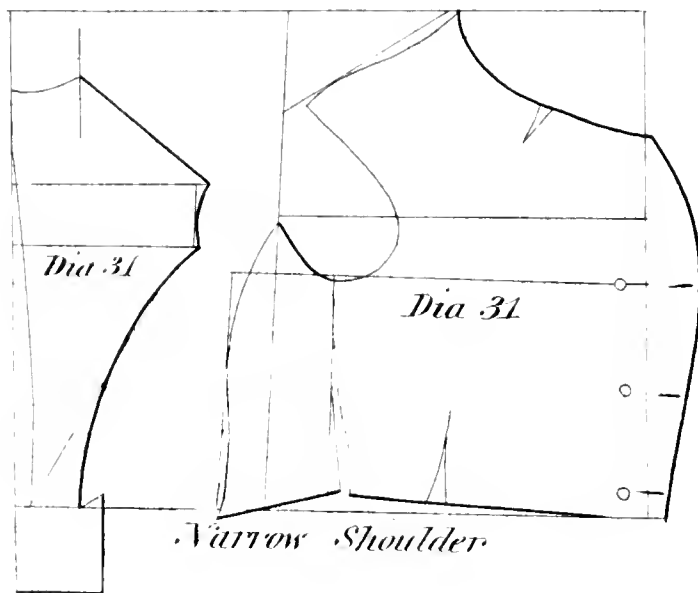
**DIAGRAMS Nos. 29 & 30**

Represent a pair of Pants drafted in separate parts, showing the manner, and how and where to shrink them before putting them together. All pants ought to be shrunk, more or less, over the instep of the foot, and below the hip, as shown on the diagram; this must be done before the pants are put together, as it is impossible to accomplish it afterwards. Diagram No. 30 represents a side view of the same pants after they are made; they are of a medium size, and slightly sprung at the bottom, showing the manner that such pants ought to appear in when made, but must be shaped before put together, as it cannot be done afterwards; no matter how much they may be pressed into form, they will not retain it for one day, if not done at the proper time.









**DIAGRAM No. 31**

Represents a narrow Shoulder and Back, showing the manner of reducing the Shoulder and Back. The Shoulder and Back can be increased in the same manner as it is reduced, by referring to the diagram. This method will be easily understood, and found to be a correct principle.

**DIAGRAM No. 32**

Represents the corpulent form of drafting the fore part and back, showing the amount of cloth brought forward of the base line, instead of the ordinary manner of drafting for a proportionable figure. The corpulent person will require a much narrower back, in proportion to the size, and the shoulder thrown further back, and much longer in the gorge. As a natural necessity, in order to fit the chest, refer to the diagram for the manner of executing a draft of this kind.

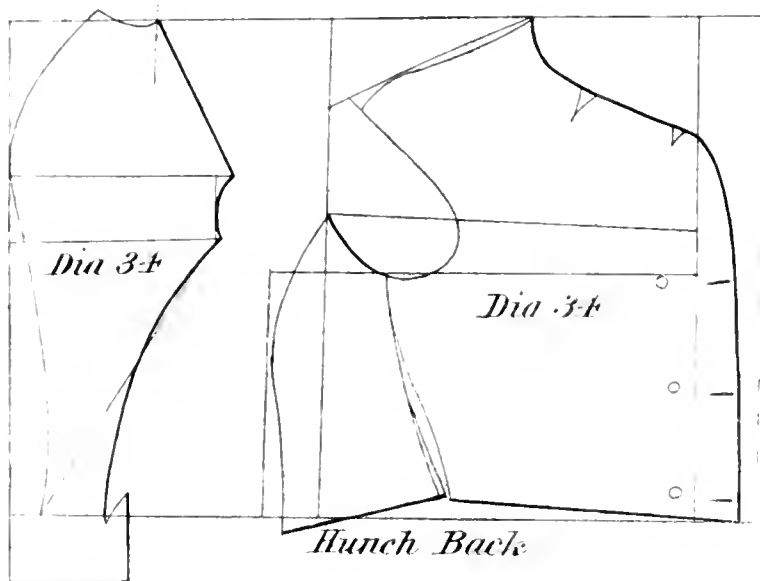
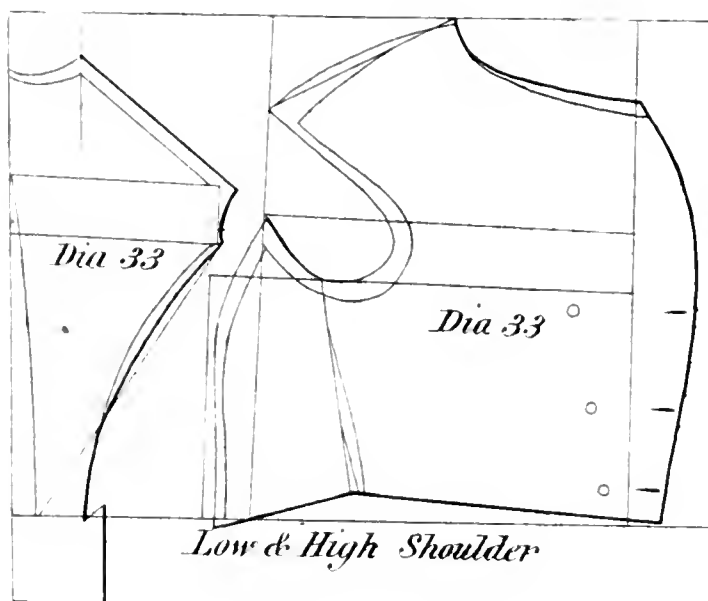
**DIAGRAM No. 33**

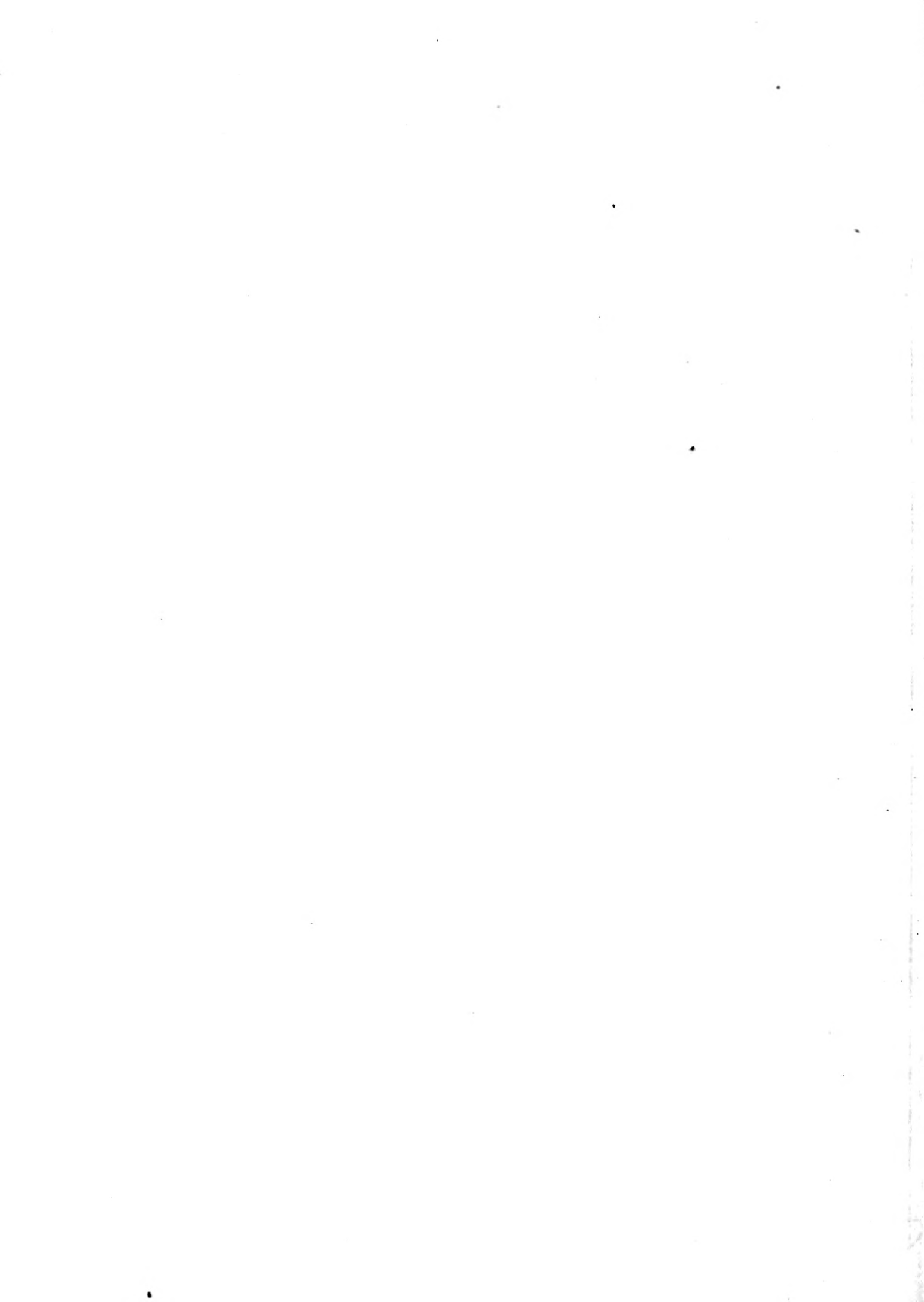
Represents the High and Low Shouldered form. In this figure it is necessary to measure both shoulders, in order to find the difference of size between them. The manner of cutting and building a garment for a figure of this kind is explained in another part of this work more particularly.

**DIAGRAM No. 34**

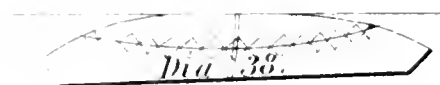
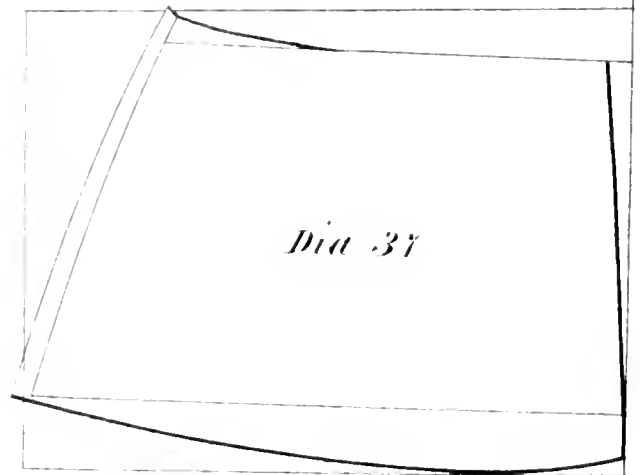
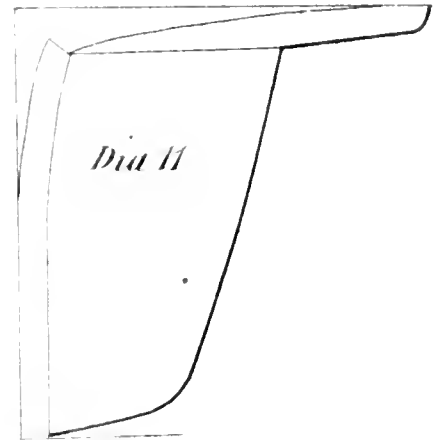
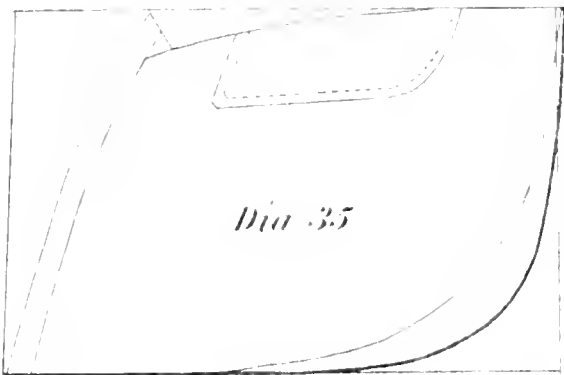
Represents the Hunch-Back form. This is the most difficult garment in the whole profession to fit, which will be found, upon measuring and drafting, to correspond with this diagram; almost in every case of a hunch-back the shoulders are rather narrow, as a natural consequence. Refer to the diagram, which will show the manner that a draft for such figures will appear though it may seem rather strange to some Cutters, still it is quite correct.











**DIAGRAM No. 35**

Represents the skirt of a Business or Shooting Coat, showing two styles of front and the manner of lowering the waist seams at the back part of the seam. When a skirt is cut in this manner the side body requires to be lengthened in proportion to the lowness of the skirt. This style has a very good effect in a coat of this kind when produced in a proper manner : otherwise better leave it alone.

**DIAGRAM No. 36**

Represents the skirt of a Morning Coat showing the transverse and the rounding front as made in this kind of a coat. There are many Cutters who cannot draft a skirt separately, but this work will obviate that for the future.

**DIAGRAM No. 37**

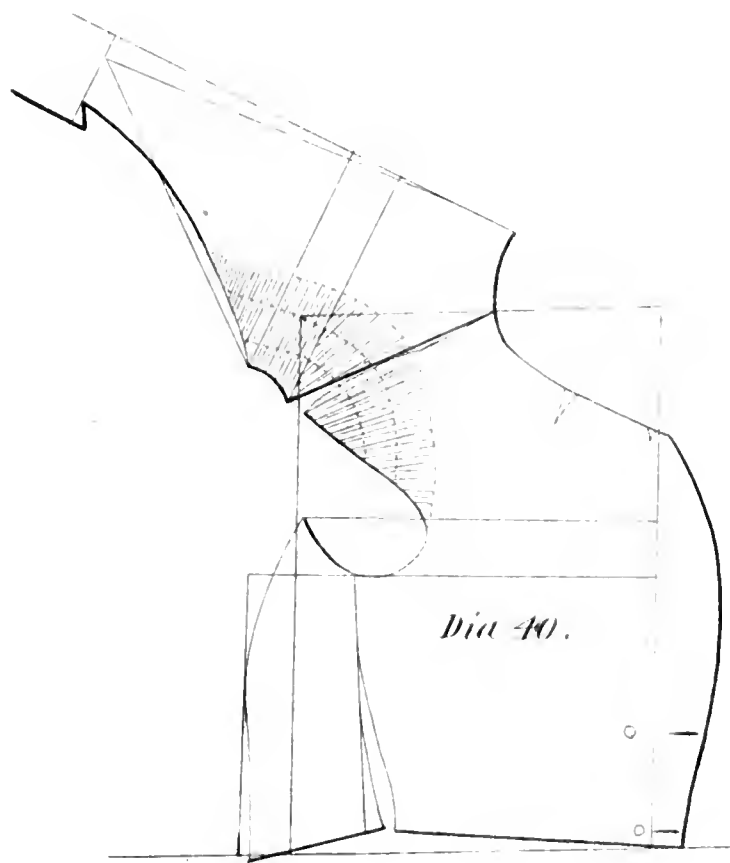
Represents the skirt of a Double-Breasted Frock Coat. My object in giving skirt drafts separately is to show the manner of drafting skirts alone, as every Cutter, at one time or another, has occasion to cut a skirt for a coat that has lost its former skirts accidentally, or otherwise. I have met many a Cutter that did not know how to commence to draft a skirt separately, and to obviate this necessity I have given the skirt diagrams drafted in the usual manner by the system.

**DIAGRAMS No. 38 AND 39**

Represent the Collar unmade and made. Diagram No. 38 shows the under part of the collar ready to be shrunk into a half circle. The upper collar will require to be shrunk and fitted to the under collar, as shown on Diagram 39 before it is put on the coat. Sometimes collars are cut the outside straight, and at other times curved, but the proper time to shape the collar is after it is shaped into form. A collar may be ever so well shaped before it is made, its original shape is lost in the shrinking and curving it to the desired style, therefore the proper time must be after it is formed into shape.

**DIAGRAM No. 40**

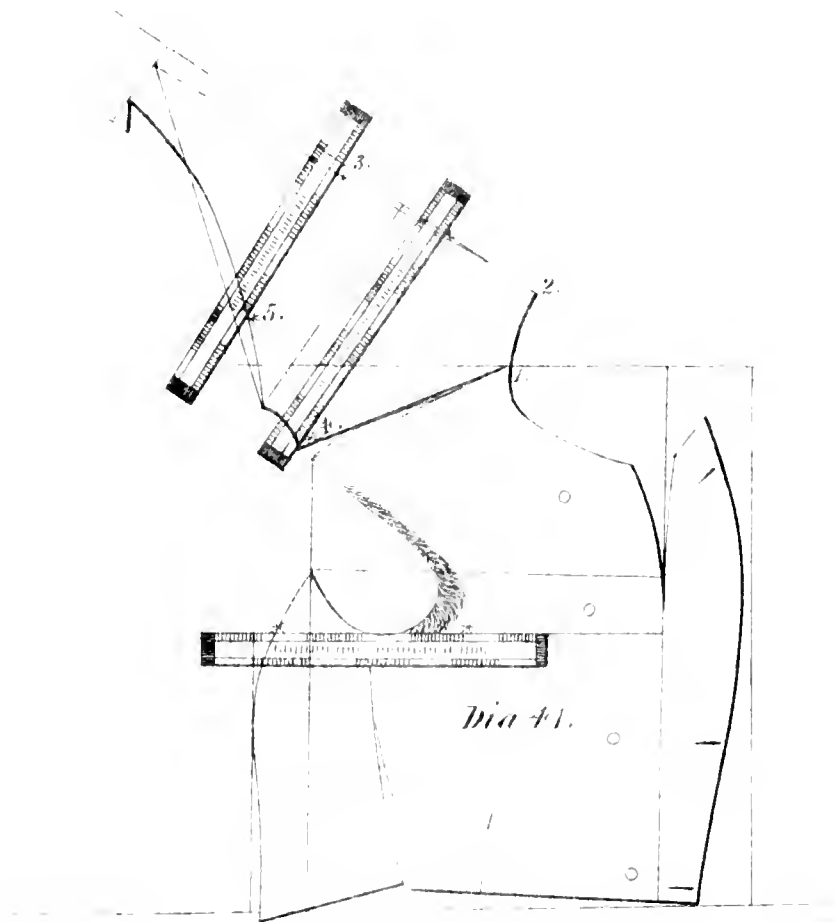
Represents the fore part and back matched together, showing the manner of building the shoulder back scye and top of side body seam of the back for a low shouldered figure or any deficient shoulder; if padded and built in this manner it will enable any Cutter to make a perfect fit for the most drooping shoulder or shoulders that can be produced. This is one of the great sciences where the tailor makes the man—or rather the appearance of a well made man. I have no knowledge whatever of any inventor or teacher heretofore giving such valuable information to the profession as is given in this diagram alone.









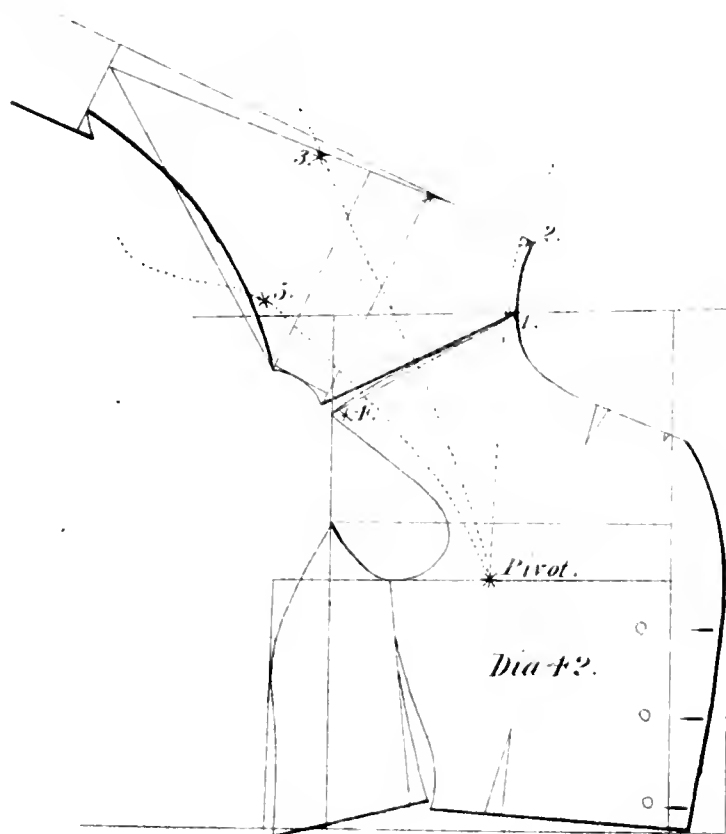


**DIAGRAM No. 41**

Represents the fore part and back matched together, and shows the manner in which the gauge is applied to the body to find the proper points ; the first gauge on the back gives the exact rise of the back from the shoulder points to the socket bone of the neck. The second gauge gives the exact depth of seye and the proper length of shoulder and all its points, and the third gauge on the back gives the rise of back in line with bottom of seye and the test measure No. 3 from the point one inch in front of seye. The style of gauging the body, and the measures taken from these points as shown on the diagram will at all times ensure a perfect fit.

**DIAGRAM No. 42**

Represents the fore part and back, showing the manner of applying the tape measure to the body, after it is gauged, as shown on the diagram. First place from the end of the tape, measure on the pivot one inch in front of the scye, then proceed up to the fore shoulder point, and mark ; then on to the socket bone, at the back of the neck, and mark ; then over the middle of the shoulder, and transverse on the back to point No. 3, in line with bottom of scye, and mark ; then to the shoulder point, at the top of back scye, and mark, and on to point No. 5, on side body seam, and mark. This concludes all the test measures, and if properly attended to, will never fail in producing a perfect fit in every instance, whether your subject is stooped, erect, high or low shouldered. Hunch back, or any other back, the result will always be the same, a never-failing one.





TAILORING is the most ancient and honourable profession in existence. The oldest man of whom we have any record must have been something of a tailor himself, as tradition distinctly says that he sewed leaves together and made himself an apron, &c.

This old gentleman tailor was no less than Mr. Adam, the father of all creation. Therefore it behooves every tailor, in whatever clime his lot may be cast, to look upon his profession with admiration at its industry, intelligence and integrity, and honourable, because the tailor never lives by fraud, deception, etc., as practised by members of the more refined and educated professions. The tailor's whole ambition is to do his fellow-man all the good that lies within his power, and to clothe the nakedness of the human family, while he himself lives by the sweat of his brow and his own industry. In whatever sphere he may move, his work and his business are of more importance and indispensable to mankind than that of any other profession. Tailoring, like every other branch of business, is divided into several branches, such as the master tailor, the cutter or foreman tailor, and the sewing tailor. The first, or merchant tailor, is a man equal in all respects to any leading man in any other profession. He may not be in all cases as highly educated as a first-class lawyer, or a doctor, but his business does not demand it; speech-making is no part of his business, neither are latin phrases in labeling parcels. A good sound English education, good judgment, punctuality, and morality, these are the requisites so essential to success, and so long as he practises them he may bid defiance to his compeers. Now the cutter, or foreman tailor, is a man of refined intellect, and of good judgment, as his profession demands it. Without this ability he cannot be a cutter, otherwise he would be a failure; in fact a good cutter will always be found to be a gentleman in every sense of the word. His intercourse with men of society will necessitate him to be a man of position and ability, which entitle him to a salary ranging from one thousand to five thousand dollars per annum, which is a larger amount of income than is received by any other second class professional in the world. The word second-class is only applicable to the salary, not to the abilities of the man, in fact a cutter must be something of an artist as well as a designer to be anything like proficient in the art of cutting.

Then compare the third-class, or sewing tailor with any other class of mechanics, and you will find that the tailor earns or makes higher wages than any other class of mechanics. This speaks well for the tailor, and shows that, if he is but true to himself, and studies sobriety, and cultivates his intellect, he may aspire to the highest honours that his country can confer upon him. At all events the tailoring business will maintain its independence and superiority over all other professions to the end of time. In whatever sphere a man may be, from the highest to the lowest,

if from nothing else, necessity compels him to patronize and to humble himself to the tailor's inch tape—humble did I say, it ought to honour. It is often that the tailor has to make the man, or rather give him the appearance of a man, by hiding his defects by the art and skill of his profession only known to himself. Tailoring is a profession by no means that there is anything of a low menial work to be done in, but on the contrary, the work is light and clean from the beginning to the end ; in fact there is no trade or profession that man has to perform but has more or less of filthier work than the tailor has to do. The tailor can keep himself as clean and respectable as any gentleman while he is at his work, and that is saying a great deal more than any of the so-called refined professions can say. Consider the doings of an M.D. from the beginning to the end, and you will find that he has to perform work both disgusting and menial, unknown but to himself and his victims. A tailor would not condescend to do such work ; it is below his independence and condescension, and he would reckon it irredeemable to his character.

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#### INSTRUCTIONS IN TAILORING.

Now, I will endeavour to give as perfect a method of building a Double-Breasted Frock Coat as possible, and, if adhered to, will never fail in producing a garment of a graceful appearance which will retain its perfections as long as it is a coat. First examine the job and ascertain if it is correctly trimmed, and, if not, report immediately to the cutter. Begin by sewing all the fishes and press, at the same time stretch the side body seam if shorter than the fore part ; then take the two fore parts and baste slightly together ; then shrink back the fulness to the centre of the breast and stretch the fore seye as shown on diagram No. 42 ; having the fulness pressed to centre in this manner, the lapels or front will roll to any desired part of breast high or low ; then baste and seam on the lapels and side body and press well ; then cut the canvas two inches back of the front seye and two-thirds the width of the bottom of the fore part, cut fishes out of the canvas to match the cuts of the fore part, sew up the cuts of the canvas, damp and press to match the fore parts ; then fit the canvas to the fore part and pad the breast and lapels thick and neat ; then cut the hair cloth two inches back of the brake of the lapels at the gorge and down the front to 3 or 4 inches from the bottom or waist seam, and up transverse the breast to the middle of the fore seye, the hair cloth should be shrunk, bound with silesia and padded firmly to the canvas with two ply of wadding between them, this will give a full rounding appearance to the fore part ; then sew the skirts to the fore parts with fulness, or without, according to the fashion, press the waist seams



well and press back the fulness to over the hips ; then cut the facing and side body linings, cut out fishes to match the fore part, sew up and pad into form lightly and neatly, shrink the facing to match the fore part and stretch the fore scye and baste them in commencing at the centre of the breast from side to side, and not up and down as is usually done ; be sure that the facing and side body lining are as long as the fore part, then put in the skirt pockets, stay them well to plait and up the waist seam, the front and bottom ; then finish the lapels and press smooth the fore part and skirt and put in the button holes, as it is much easier at this stage of advancement than it would be when all the parts are put together ; then seam the right and left backs to the side bodies, keeping the tops of the side bodies a little easy on the back, seam down the back skirts and the centre seam of the back, now press well and be careful not to stretch the side body, seam stays across the back from tack to tack and put in the back tack and the back skirt linings, fell over the side body seams ; then seam the sleeve and sleeve linings and press ; measure the sleeves heads to the scye and draw in the fulness and press back ; then sew in the sleeves and press well and carefully, and if the heads are full put in a small pad, which will raise the heads and give the shoulder a square and graceful appearance ; fell the sleeve linings over the scye and smooth down to the cuffs and fell all round ; then canvas the collar, draw in for the stand and press into shape and fit it to the gorge and pare off in good shape ; now shrink the upper collar to match the under one, then put on the collar by commencing at the centre of the collar on the back seam and sew on both ways and cover with the upper collar ; then press off carefully without altering the shape the coat was built in ; then put on the buttons and the coat is finished in a shape that will fit the customer if it was cut to the size. A coat made as described here will be made well, and will never get out of shape. The breast pocket is omitted in this description : breast pockets are put in the facing in the same manner as the outside pockets in sack coats, only they are getted instead of welts.

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#### INSTRUCTIONS IN VEST MAKING.

First examine the vest and trimmings and ascertain if it is correctly trimmed, if not, report immediately to the cutter. Then begin by cutting the pockets to the desired size, stay all round the cuts and put in the pockets, stay the welts and tack the pockets neatly whether bound or unbound ; then put in the canvas the whole width of the shoulders and tranverse down the breast to the bottom four inches wide ; then put on the under collar and fit up the facings and fore part linings and press ; then seam, fell or bind the edges, and fell fore scye, overcast the shoulders and side

seams, and put in the back seam, the side seam, bottom and shoulder seams ; then turn out the fore parts and fell the back of the collar, put in the button holes and and press off and put on the buttons, and the vest is finished. Some vests are wadded and some are not, and if wadded tack it well to the canvas. Washing vests should never be canvased, but stay the buttons and button holes ; seam the collar in with the shoulder seams and fit a piece of cloth the same as the fore part to the back, shape it so as to fit the back of the neck : this will be much neater than having the collar to go all round.

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### INSTRUCTIONS FOR MAKING PANTALOONS.

First examine the job, and ascertain if all the different parts of the pants and trimmings are correct, and, if not, report immediately to the cutter, then match the fore part and back, and see if they will go together, as they ought to, and, if not, get them rectified before proceeding any further, then shrink the fore parts according to the fashion. All pants ought to be shrunk, more or less, in the fore part, over the boot ; if spring bottom, it will require all that the cloth will give. In tight-fitting pants, it is necessary to shrink the back part, below the hip, and over the thigh ; this will do away with a certain amount of the surplus cloth not wanted in this part of the pants, then begin by putting in the pockets, and stay them well ; fit up the flys with double staying, and put in the button-holes, and put on the buttons ; press the pockets and fly, then baste the leg seams, and seam them up ; press the seams, and tack the pockets strong and neat, then sew on the waist bands ; stay with double linen, and put on the buttons and waist band linings ; fell or bind, as the case may be, then seam up the back and crutch seams, and tack the bottom of the fly, and turn in the bottoms to the desired length, then press off carefully, so as not to take out the spring in the fore part. If the pants are not shaped properly before being put together, it can not be done afterwards, or in the pressing off. It is erroneous to think that pants can be shaped into any desired form after they are made ; sometimes pants have canvas in the bottoms, and sometimes they have not. Pants that are lined can never be as well shaped as pants that have no lining in them.

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### HOW TO TRIM ALL KINDS OF GARMENTS.

A great number of cutters are not in the habit of trimming their work, but block off every part of the trimmings, as it is generally termed by the trade ; this leaves

a great margin to the tailors to cabbage, as the saying is. By these means the employer is defrauded out of an enormous amount of material from one end of the year to the other ; in fact, I have known tailors often to remark that they did not much care to work for a shop where the cutter was in the habit of fitting up the jobs. I would recommend every merchant tailor or employer to pay their work hands the highest figure for their work, and get it well done, and let the cutter trim every job that he cuts, and trim it carefully, and I shall not hesitate to say that the employers will be the gainers at the end of time, if they adhere to this manner. In some shops it may be impossible for the cutter to accomplish all this work, but in all such cases I would say to the employer that it is much better to employ more help in their cutting departments than to neglect so essential a part as the trimming of the job. It would not be judicious to the employer to over-crowd the cutter with work ; in all such cases the cutter is more liable to mistakes than he would be otherwise. The success of every tailoring establishment greatly depends upon the merits of the cutter ; a good fitter and fashionable cutter will at all times and in every place command a large share of patronage, and no doubt is the main-stay of any tailoring establishment. Now I will endeavour to give as correct a manner as possible to trim all kinds of garments ; in the first place I will begin with the coat ; after all parts of the coat are cut, fit up the facings, then cut the length of canvas required, which will be the length of the fore part in the body coat, or down to the side pockets in a sack coat, one quarter of a yard linen stay, more or less, according to the size or quality of the garment ; then cut the pockets to the desired size, and the number wanted in the garment ; then cut the lining, first the back and side body, then the skirts and back skirts, and the fore parts, if the cloth or facings do not extend to the side body centre seam ; then the padding and hair cloth, if any, and one and a half to two yards wadding ; buttons according to the number required, or fashion ; one thread of twist for each button hole, one yard and an eighth long, and four to six skeins of sewing silk ; if made by hand, or if made by machine, one to two skeins will be quite sufficient. Linen thread is only used to put on the buttons, unless the garment is made from coarse material, then use more linen thread and less sewing silk ; if the coat is bound an ordinary size, will take from four and a half to six yards binding. A coat that is bound all round will take, as a natural consequence, more than a coat that is only bound round the first points of the skirt ; this comprises all the trimmings necessary to build an under coat of any kind, unless a silk velvet collar or silk facings, which is seldom in use by the better class of tailors.

The Over Coat is trimmed in the same manner as the under coat, except when interlined, which will take the same quantity of material as the outside lining ; the interlining should be the lightest cambric obtainable, in order to prevent the lining from being stiff ; the more pliable the lining is, the better, as stiff linings always produce wrinkles, and prevent the coat from hanging in a graceful and easy manner.

A vest should be trimmed in the following manner :—Measure the length of the fore part, and cut the same length of French canvas, or elastic stiffening, and split it in two, and use only the half for each vest, unless it is a silk or silk velvet vest, then canvas the whole fore part ; put in from two to three inches of stay linen, half a yard of wadding, or more if required ; the pockets will be obtained from the pieces left from the back ; the number of buttons required depends altogether on the fashion or the taste of the customer, but at all times put only one thread of twist for each button, three-quarters of a yard long ; two skeins of sewing silk, and one hank of linen thread ; if made by a sewing machine, half a skein of sewing silk is quite sufficient, and linen thread enough to put the buttons on ; if the vest is bound it will take from two and a half to three yards of binding for an ordinary size. This concludes all the trimmings for a vest, except the inside linings, which will take from seven-eighths to one yard of fine cambric or soft silesia.

Pantaloon ought to be trimmed in the following manner :—I would recommend all pants to be lined to three or more inches below the crutch or fork, by this means the body of the pants will be well stayed, and will prevent the seat from wearing out until the other parts are done, which would not be the case if not lined as described here ; but in no case would I recommend the pants to be lined all through if a well-shaped leg and bottom is to be obtained, as it cannot be done so nice with linings as without. Having the linings fitted, then cut the pockets to the desired size, which ought to be from eight to ten inches long and from six to seven inches wide, with a hip pocket two inches less both ways, watch pocket three by five inches. Some pants have only one cash pocket, and some have none. Then put in two inches of good canvas for the waist, three inches of stay linen and two inches of silesian for fly lining, and two inches of some fancy material for waist-band lining, if bound put in two yards of binding, and if canvased in the bottom put in from four to six inches all round or half round as desired, and seven brace of buttons, five fly buttons and one buckle, five threads of twist seven-eighths of a yard long, three skeins of sewing silk, and six hanks of linen thread ; but if made by a sewing machine, one skein of sewing silk and one hank of thread will be quite sufficient. An extra large size or corpulent pants will take one-third more trimmings than what is described here.

I would recommend all cutters and trimmers to have as much of the trimmings ready cut as possible, at all times, for coats, vests, and pants ; by so doing, time will be much shortened in trimming any garment. By adhering to the following rules, namely : for the coat, keep always cut the canvas stayings, pockets, wadding, and paddings ; for the Vests, canvas stayings, waddings, &c. The trimmings for the Pants can always be ready cut, as they are generally comprised of two colours, light and dark. By adhering to this method of trimming, it will greatly facilitate the Cutters or trimmers in getting over a much larger amount of work than could be done otherwise. In this manner pants can be trimmed in less time than five minutes.

# GRADUATED TABLES.

The following tables will be found to contain much valuable information, which will be of the greatest importance to Cutters in general, especially in the Ready-made Trade. These tables give the ordinary or average length of every size and style in Coats and Coat Sleeves, Vests, and Pantaloons, corresponding with the breast measure for coats and vests, and waist measure of pantaloons on the gauge. These tables are compiled from long experience and careful attention to the measurement of customers of every size and shape.

SACK COATS.			BUSINESS COATS, &c.			FROCK COATS.		
BREAST.	LENGTH.	SLEEVES.						
22 inches	... 16 inches long,	... 18 inches long.	...	...	...	...	...	...
23	... 17 $\frac{1}{2}$	... 19	...	...	...	...	...	...
24	... 18	... 20	...	...	...	...	...	...
25	... 19 $\frac{1}{2}$	... 21	...	...	...	...	...	...
26	... 20	... 22	...	...	...	...	...	...
27	... 21 $\frac{1}{2}$	... 23	...	...	...	...	...	...
28	... 22	... 24	...	...	...	...	...	...
29	... 23 $\frac{1}{2}$	... 25	...	...	...	...	...	...
30	... 24	... 26	...	... 26 inches long,	...	... 28 inches long.	...	...
31	... 25 $\frac{1}{2}$	... 27	...	... 27 $\frac{1}{2}$	...	... 29 $\frac{1}{2}$	...	...
32	... 26	... 28	...	... 28	...	... 30	...	...
33	... 27 $\frac{1}{2}$	... 29	...	... 29 $\frac{1}{4}$	...	... 31 $\frac{1}{2}$	...	...
34	... 28	... 30	...	... 30	...	... 32	...	...
35	... 29 $\frac{1}{2}$	... 31	...	... 31 $\frac{1}{2}$	...	... 33 $\frac{1}{2}$	...	...
36	... 30	... 32	...	... 32	...	... 34	...	...
37	... 30 $\frac{1}{2}$	... 33	...	... 32 $\frac{1}{2}$	...	... 34 $\frac{1}{2}$	...	...
38	... 31	... 34	...	... 33	...	... 35	...	...
39	... 31 $\frac{1}{2}$	... 34 $\frac{1}{2}$	...	... 33 $\frac{1}{2}$	...	... 35 $\frac{1}{2}$	...	...
40	... 32	... 35	...	... 34	...	... 36	...	...
41	... 32 $\frac{1}{2}$	... 35 $\frac{1}{2}$	...	... 34 $\frac{1}{2}$	...	... 36 $\frac{1}{2}$	...	...
42	... 33 $\frac{1}{4}$	... 35 $\frac{3}{4}$	...	... 35 $\frac{1}{4}$	...	... 37 $\frac{1}{4}$	...	...
43	... 33 $\frac{1}{2}$	... 36	...	... 35 $\frac{1}{2}$	...	... 37 $\frac{1}{2}$	...	...
44	... 33 $\frac{3}{4}$	... 36 $\frac{1}{4}$	...	... 35 $\frac{3}{4}$	...	... 37 $\frac{3}{4}$	...	...
45	... 34	... 36 $\frac{1}{2}$	...	... 36	...	... 38	...	...
46	... 34	... 36 $\frac{3}{4}$	...	... 36	...	... 38	...	...
47	... 34 $\frac{1}{4}$	... 37	...	... 36 $\frac{1}{4}$	...	... 38 $\frac{1}{4}$	...	...
48	... 34 $\frac{1}{2}$	... 37 $\frac{1}{2}$	...	... 36 $\frac{1}{2}$	...	... 38 $\frac{1}{2}$	...	...
49	... 34 $\frac{3}{4}$	... 38	...	... 36 $\frac{3}{4}$	...	... 38 $\frac{3}{4}$	...	...
50	... 35	... 38	...	... 37	...	... 39	...	...

# GRADUATED TABLES

FOR

## VESTS AND PANTALOONS.

BREAST.				LENGTH.				WAIST.				LEG.			
22 inches.	...	...	...	...	16 inches.	...	...	22 inches.	...	...	...	...	16 inches long.	...	...
23	"	...	...	...	17	"	...	23	"	...	...	...	18	"	...
24	"	...	...	...	18	"	...	24	"	...	...	...	20	"	...
25	"	...	...	...	19	"	...	25	"	...	...	...	24	"	...
26	"	...	...	...	20	"	...	26	"	...	...	...	25	"	...
27	"	...	...	...	20 $\frac{1}{2}$	"	...	27	"	...	...	...	26	"	...
28	"	...	...	...	21	"	...	28	"	...	...	...	27	"	...
29	"	...	...	...	21 $\frac{1}{2}$	"	...	29	"	...	...	...	28	"	...
30	"	...	...	...	22	"	...	30	"	...	...	...	29	"	...
31	"	...	...	...	22 $\frac{1}{2}$	"	...	31	"	...	...	...	30	"	...
32	"	...	...	...	23	"	...	32	"	...	...	...	31	"	...
33	"	...	...	...	23 $\frac{1}{2}$	"	...	33	"	...	...	...	32	"	...
34	"	...	...	...	24	"	...	34	"	...	...	...	33	"	...
35	"	...	...	...	24 $\frac{1}{2}$	"	...	35	"	...	...	...	34	"	...
36	"	...	...	...	25	"	...	36	"	...	...	...	35	"	...
37	"	...	...	...	25 $\frac{1}{2}$	"	...	37	"	...	...	...	34	"	...
38	"	...	...	...	26	"	...	38	"	...	...	...	32	"	...
39	"	...	...	...	26 $\frac{1}{2}$	"	...	39	"	...	...	...	31	"	...
40	"	...	...	...	27	"	...	40	"	...	...	...	30 $\frac{3}{4}$	"	...
41	"	...	...	...	27 $\frac{1}{2}$	"	...	41	"	...	...	...	30 $\frac{1}{2}$	"	...
42	"	...	...	...	28	"	...	42	"	...	...	...	30 $\frac{1}{4}$	"	...
43	"	...	...	...	28 $\frac{1}{2}$	"	...	43	"	...	...	...	29 $\frac{3}{4}$	"	...
44	"	...	...	...	28 $\frac{3}{4}$	"	...	44	"	...	...	...	29 $\frac{1}{2}$	"	...
45	"	...	...	...	29	"	...	45	"	...	...	...	29 $\frac{1}{4}$	"	...
46	"	...	...	...	29	"	...	46	"	...	...	...	29	"	...
47	"	...	...	...	29 $\frac{1}{4}$	"	...	47	"	...	...	...	29	"	...
48	"	...	...	...	29 $\frac{1}{2}$	"	...	48	"	...	...	...	29	"	...
49	"	...	...	...	29 $\frac{3}{4}$	"	...	49	"	...	...	...	29	"	...
50	"	...	...	...	30	"	...	50	"	...	...	...	29	"	...









